

FIG. 1

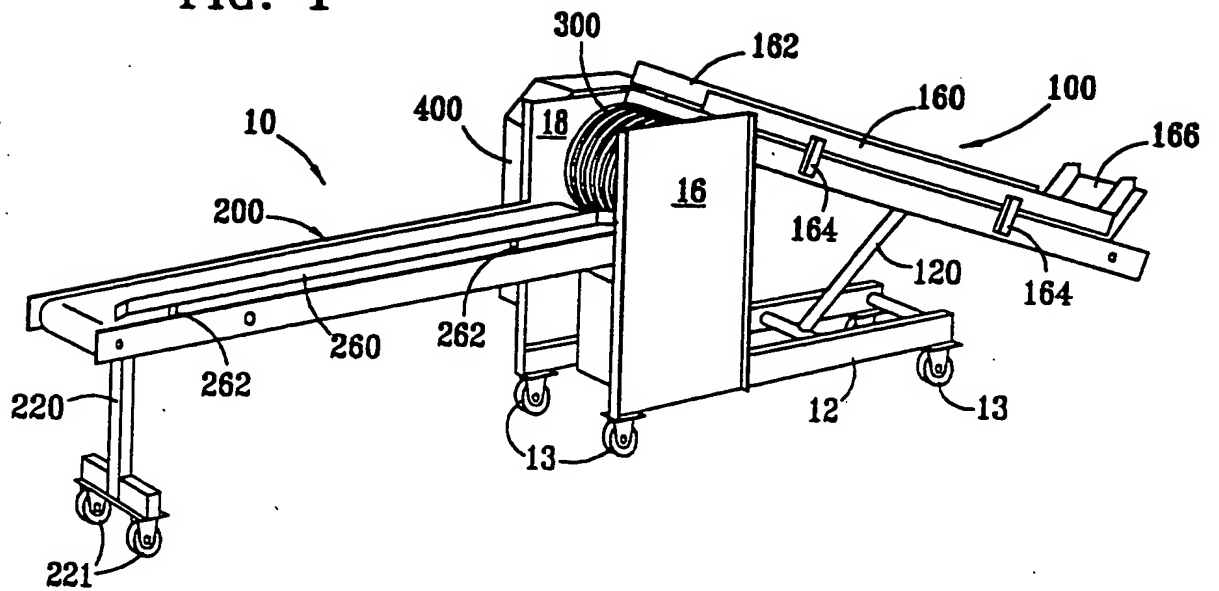


FIG. 2

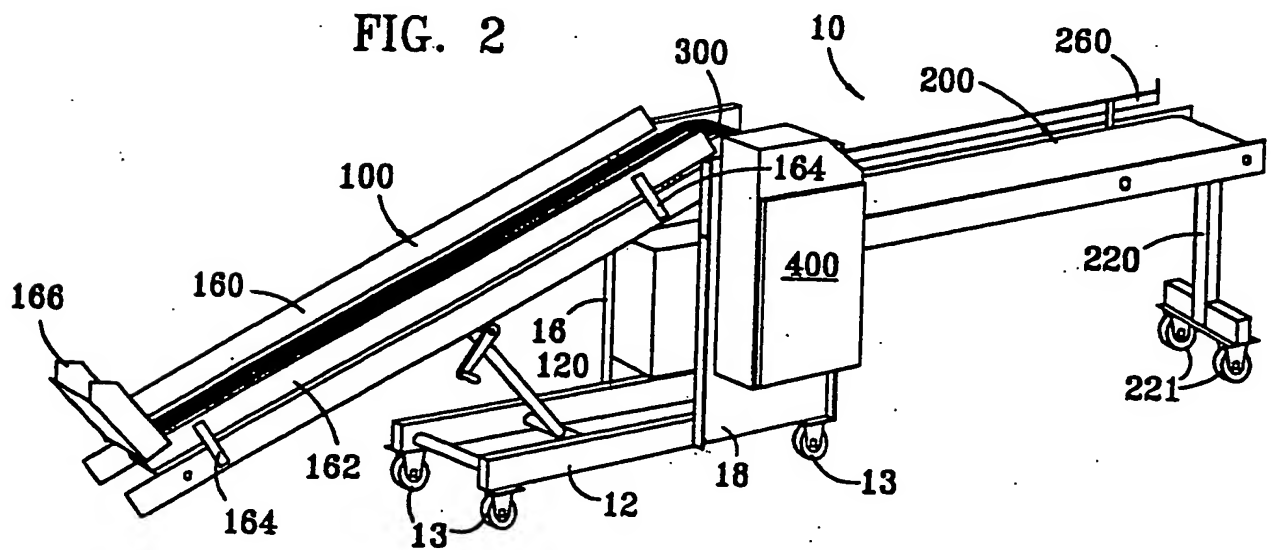


FIG. 3

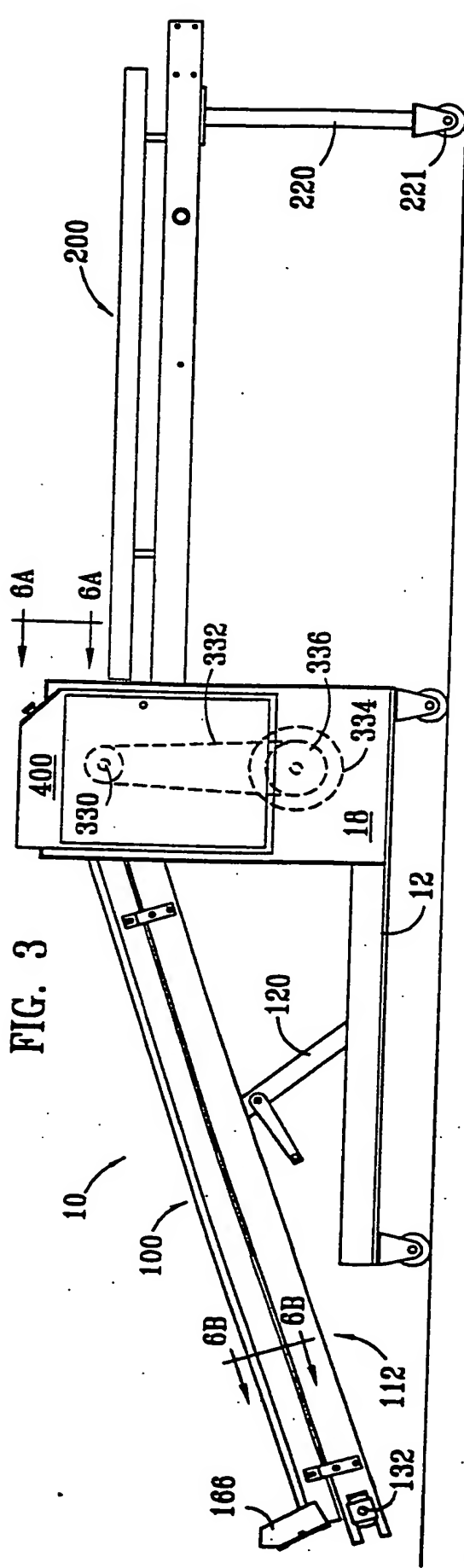


FIG. 6A

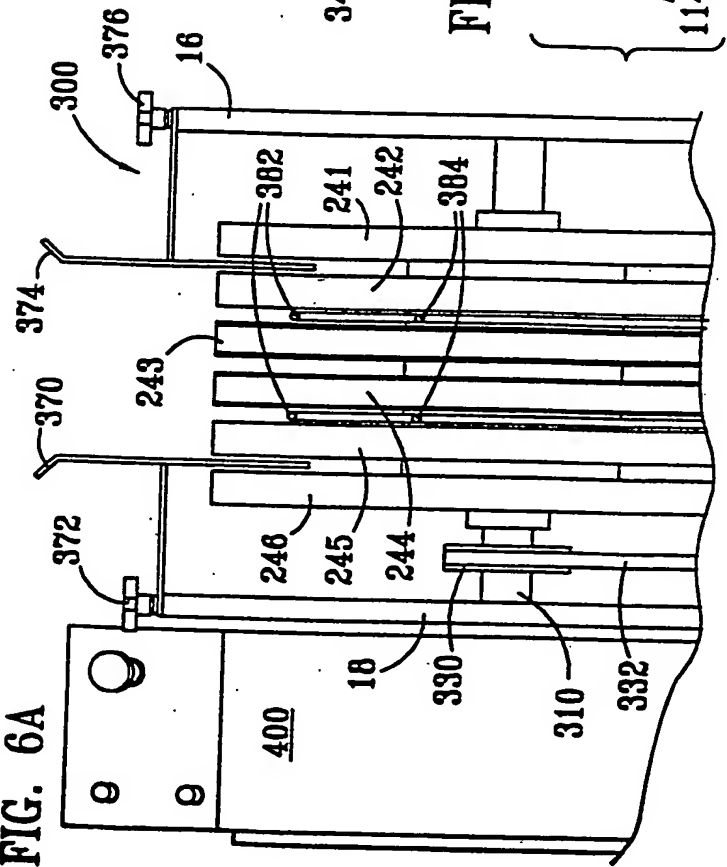


FIG. 7A

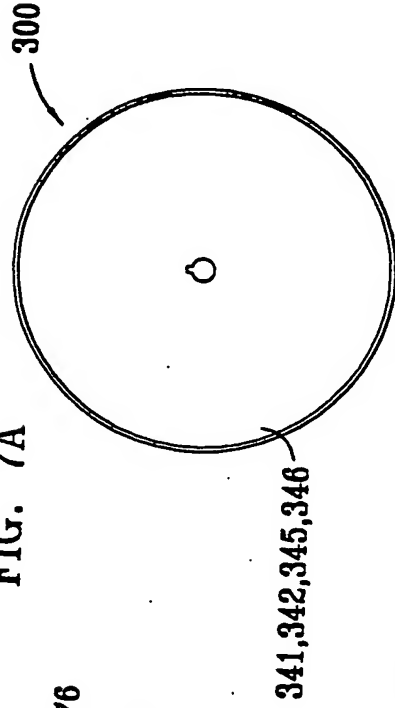


FIG. 7B  
144, 142, 145, 146

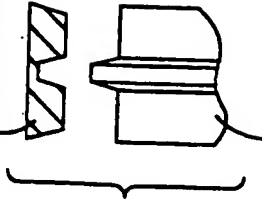


FIG. 4

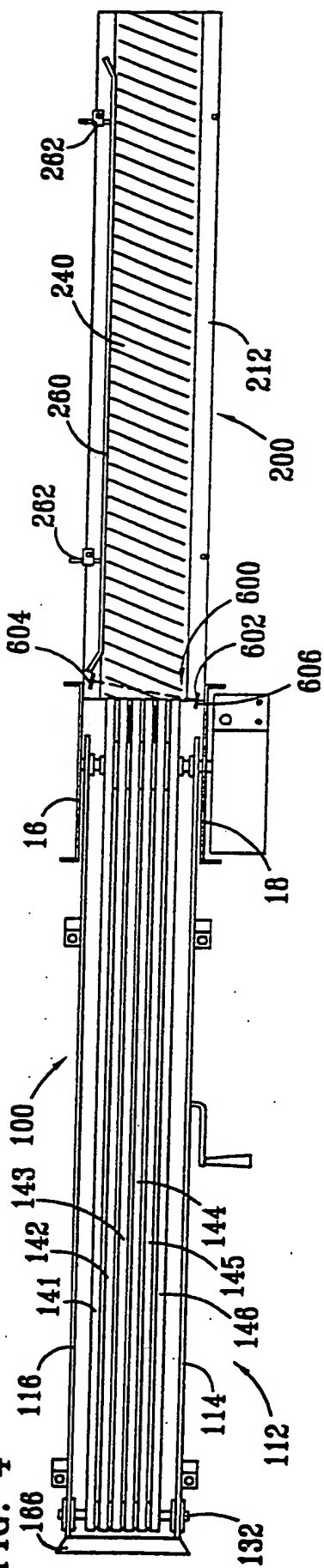
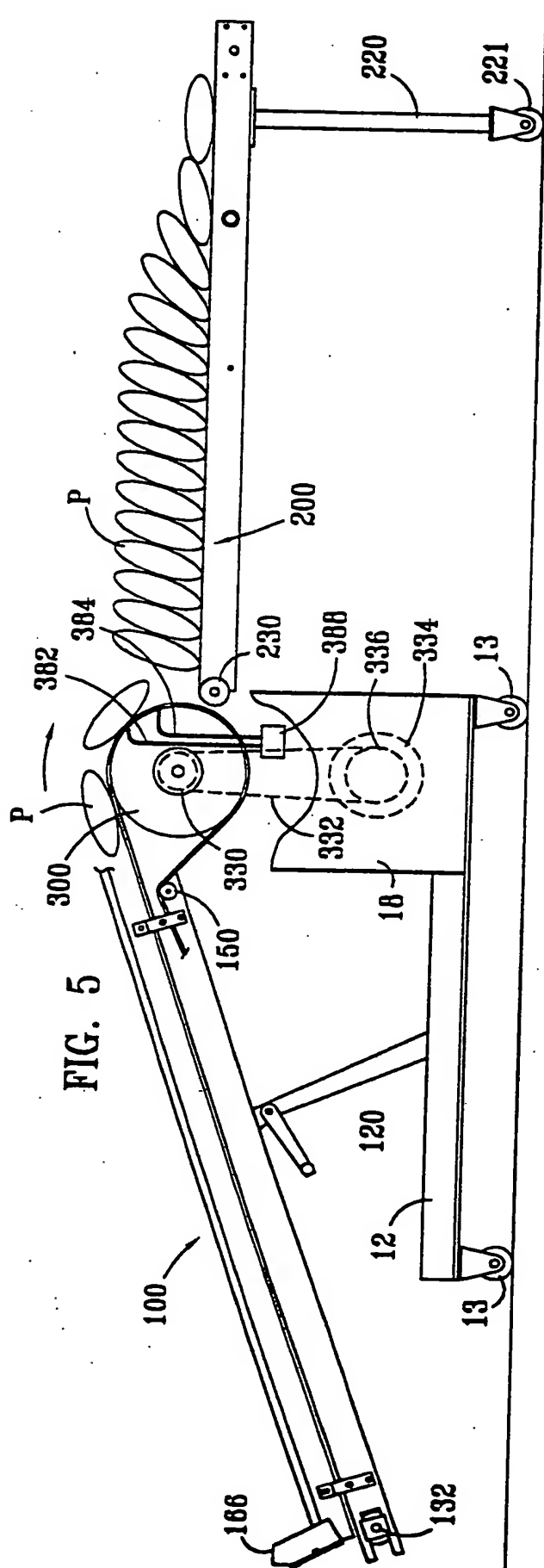


FIG. 5



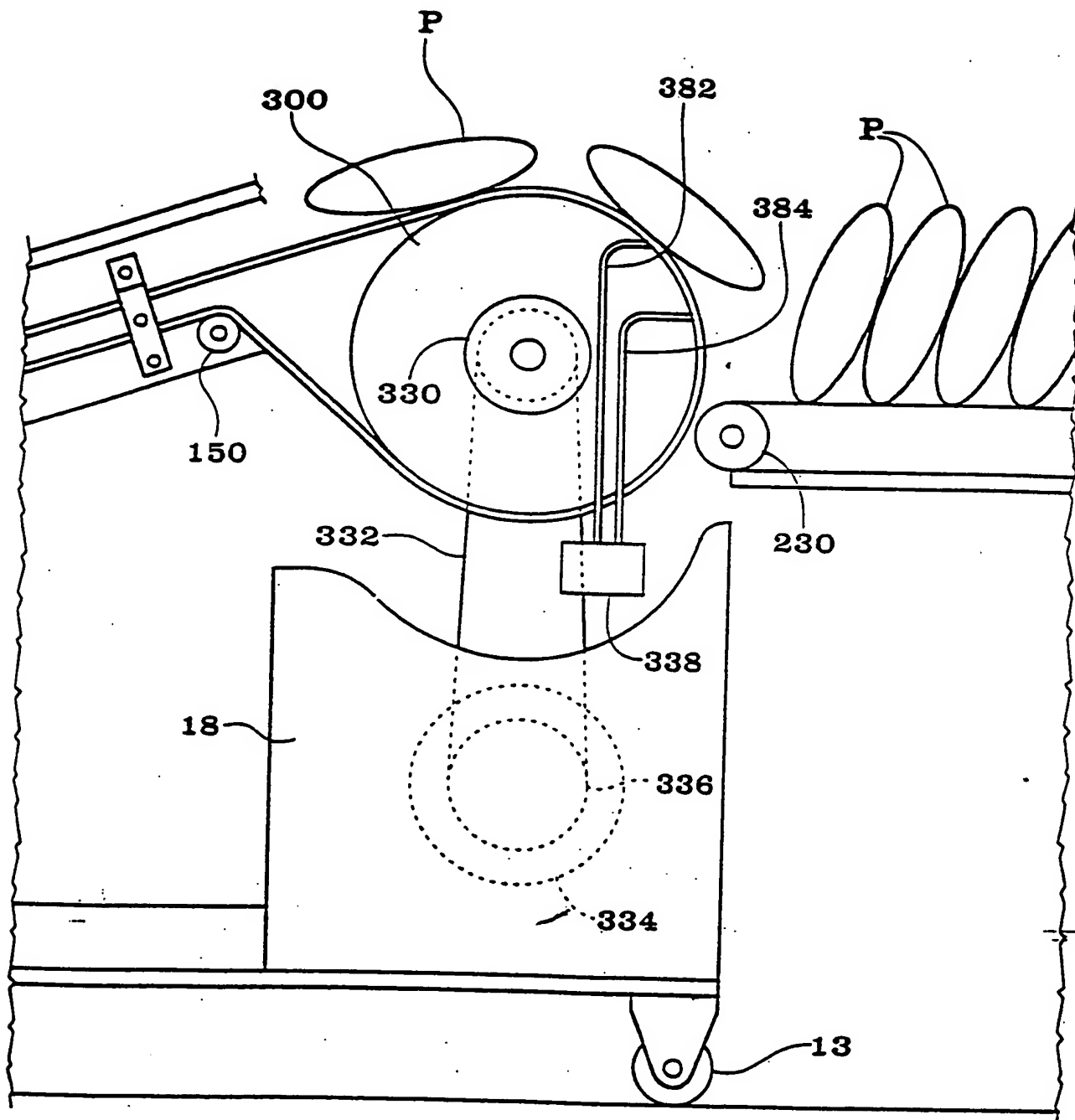


FIG.5A

FIG. 7C

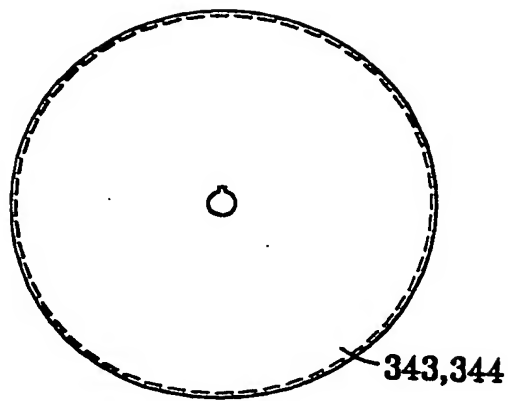


FIG. 7D

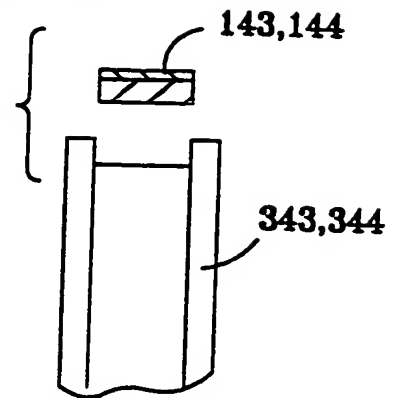


FIG. 8A

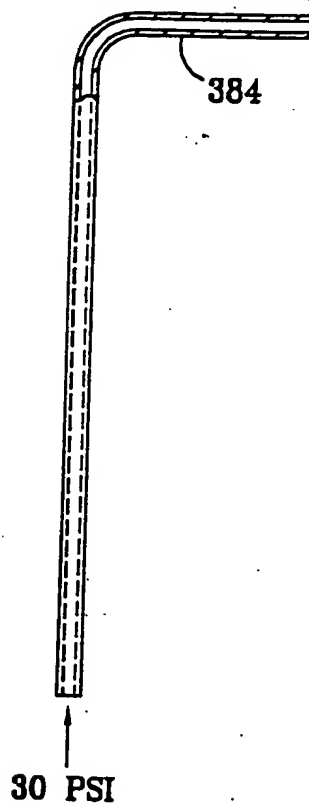


FIG. 8B

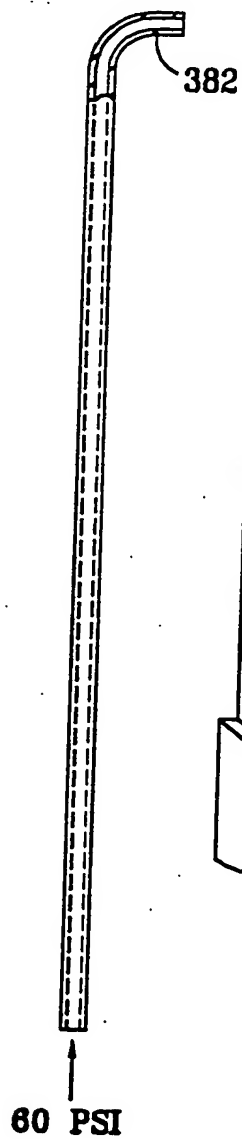


FIG. 9

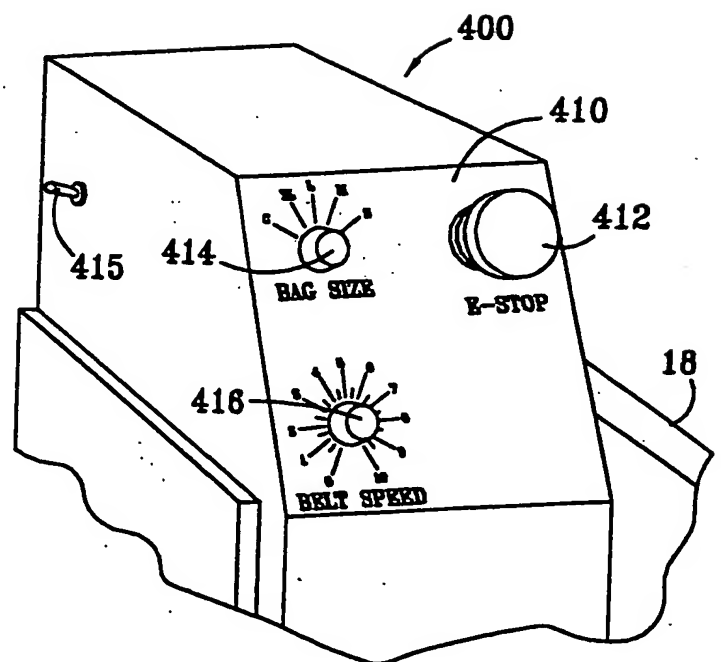


FIG. 10

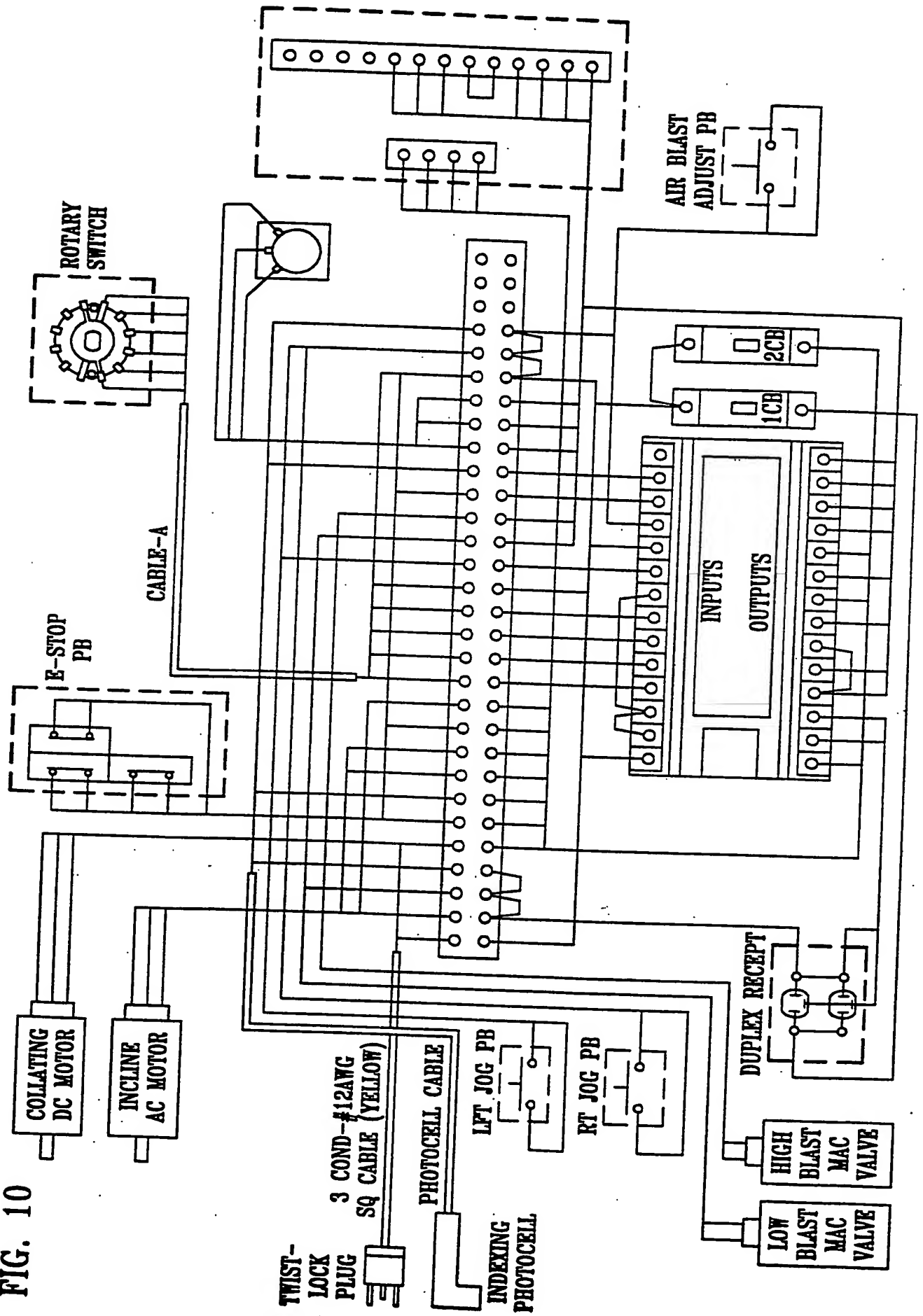


FIG. 11A

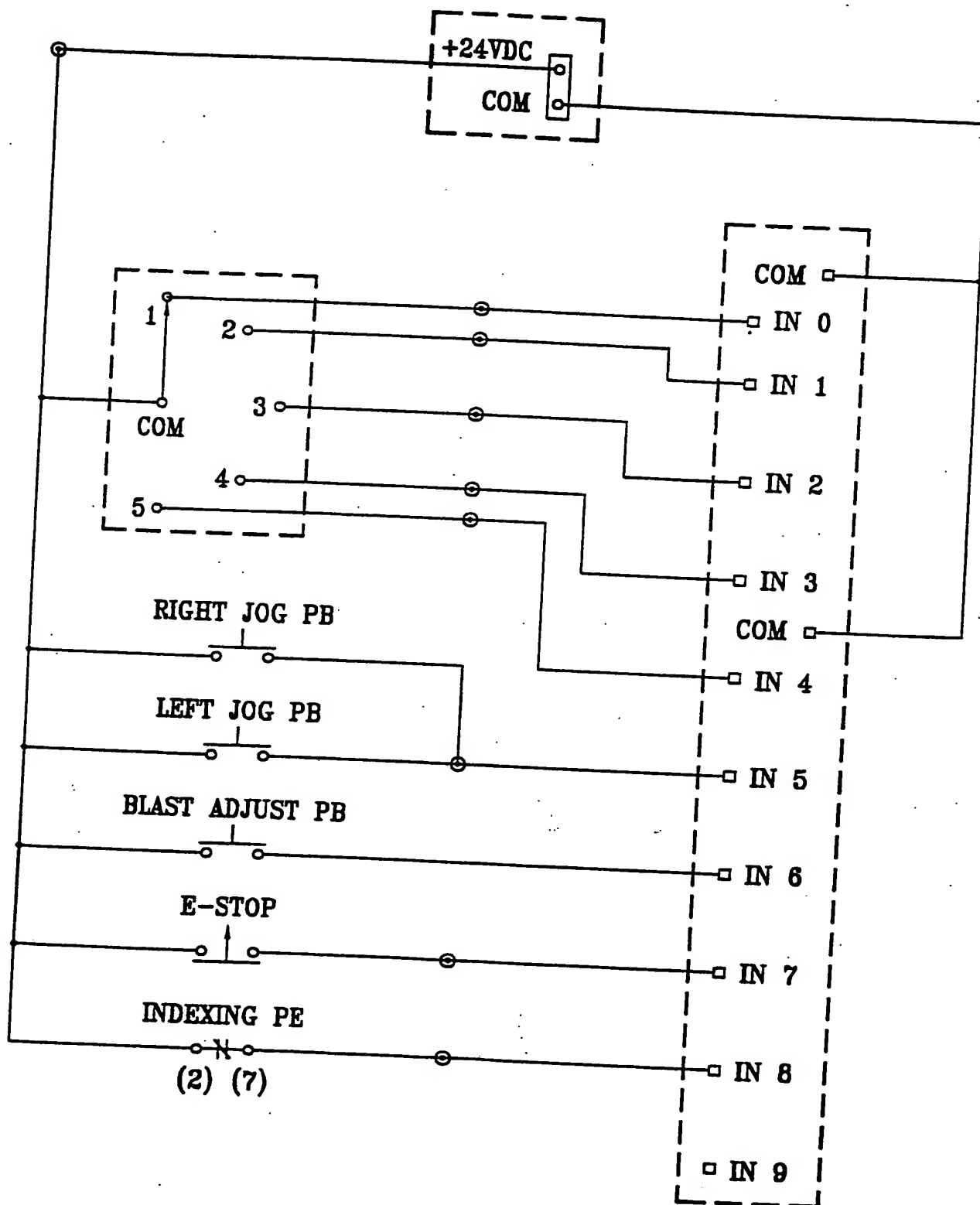
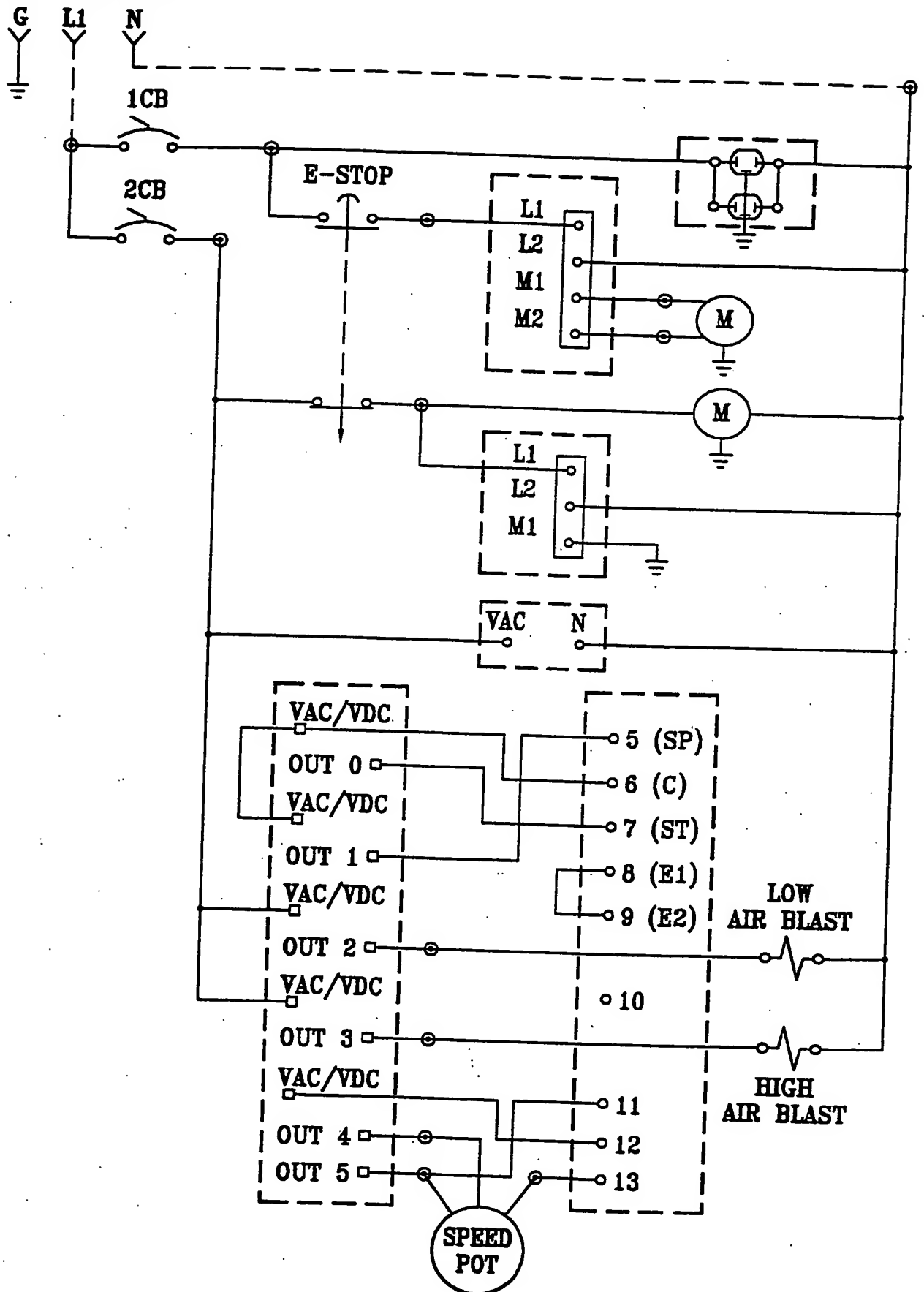


FIG. 11B

120V, 1PH, 60Hz





# AIR ASSISTED COLLATOR PROGRAM LISTING

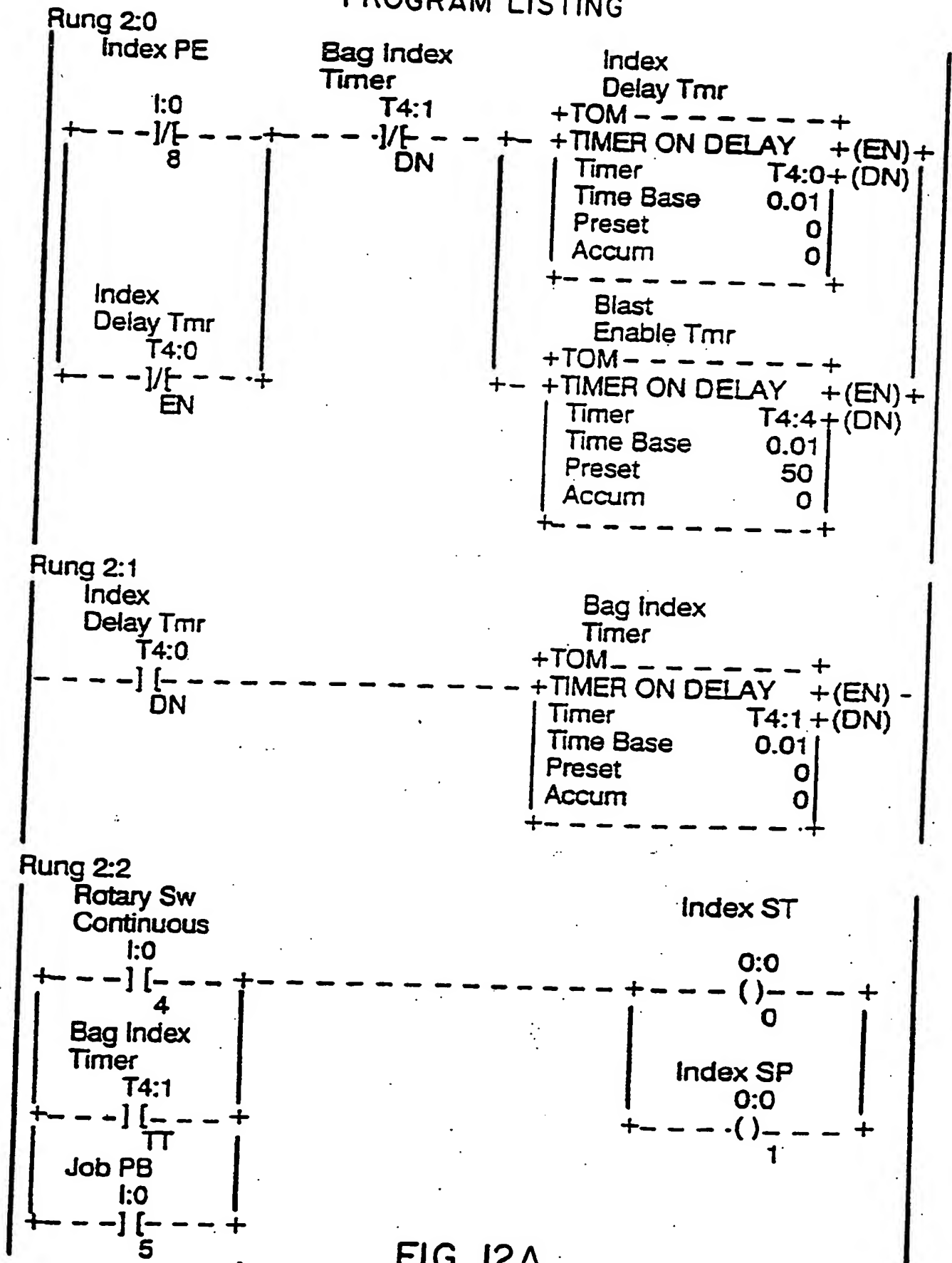
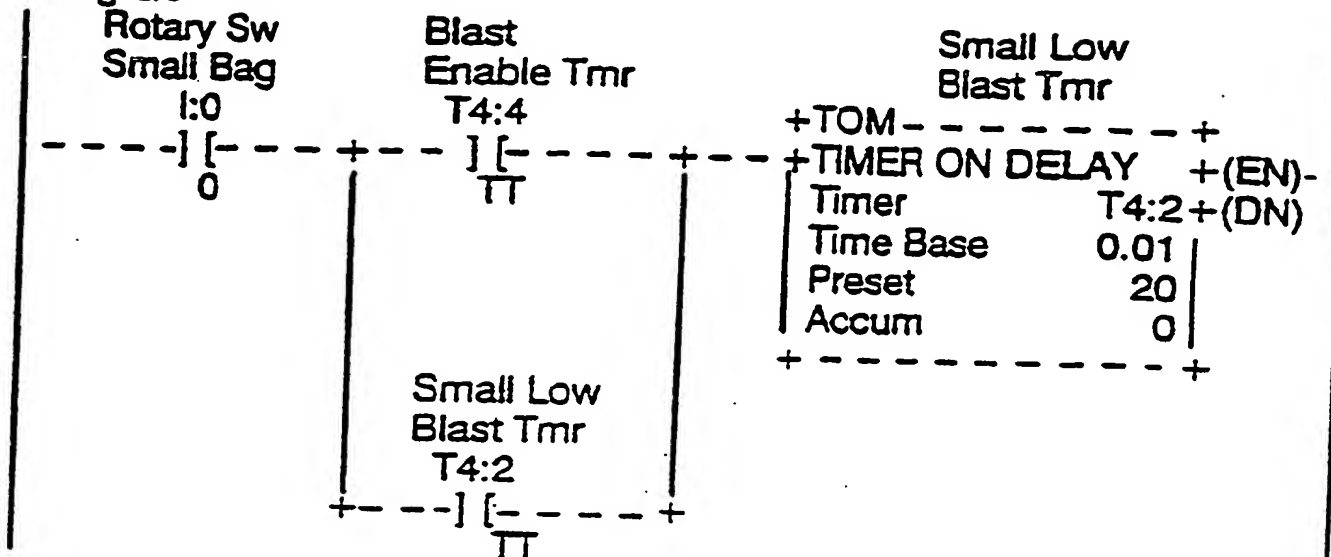


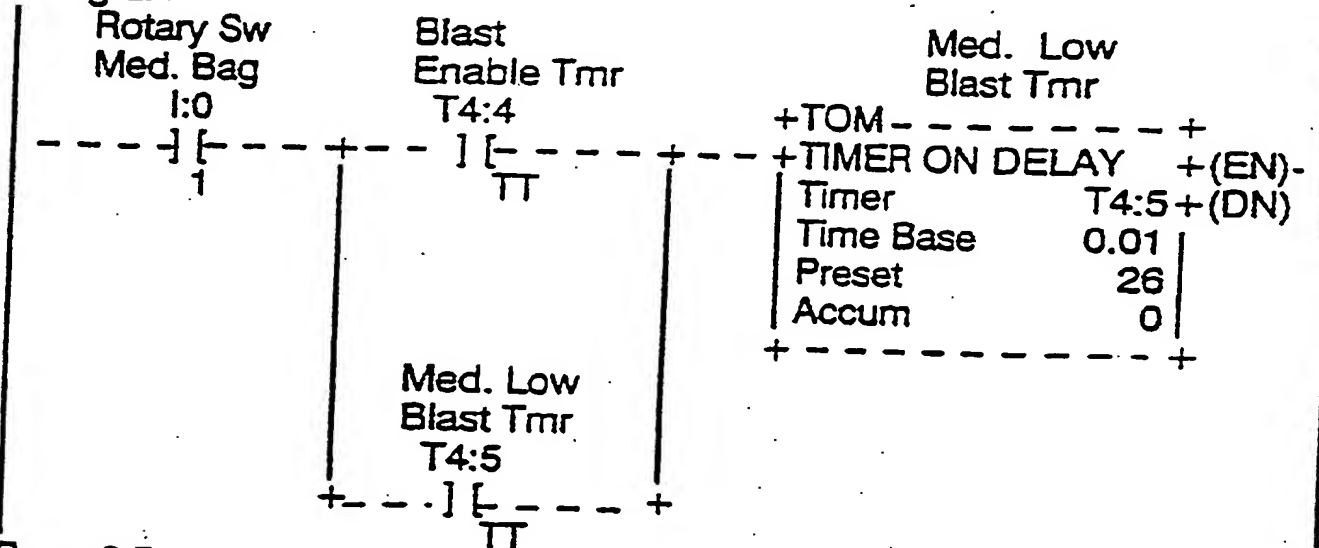
FIG. 12A

# AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:3



Rung 2:4



Rung 2:5

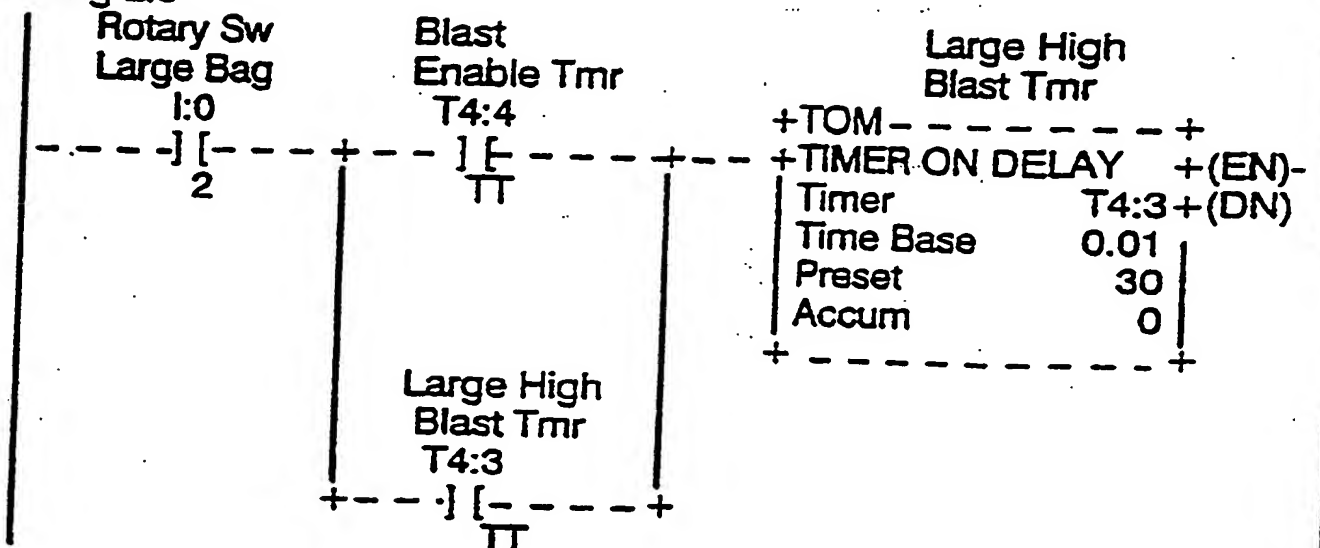


FIG. 12R

# AIR ASSISTED COLLATOR PROGRAM LISTING

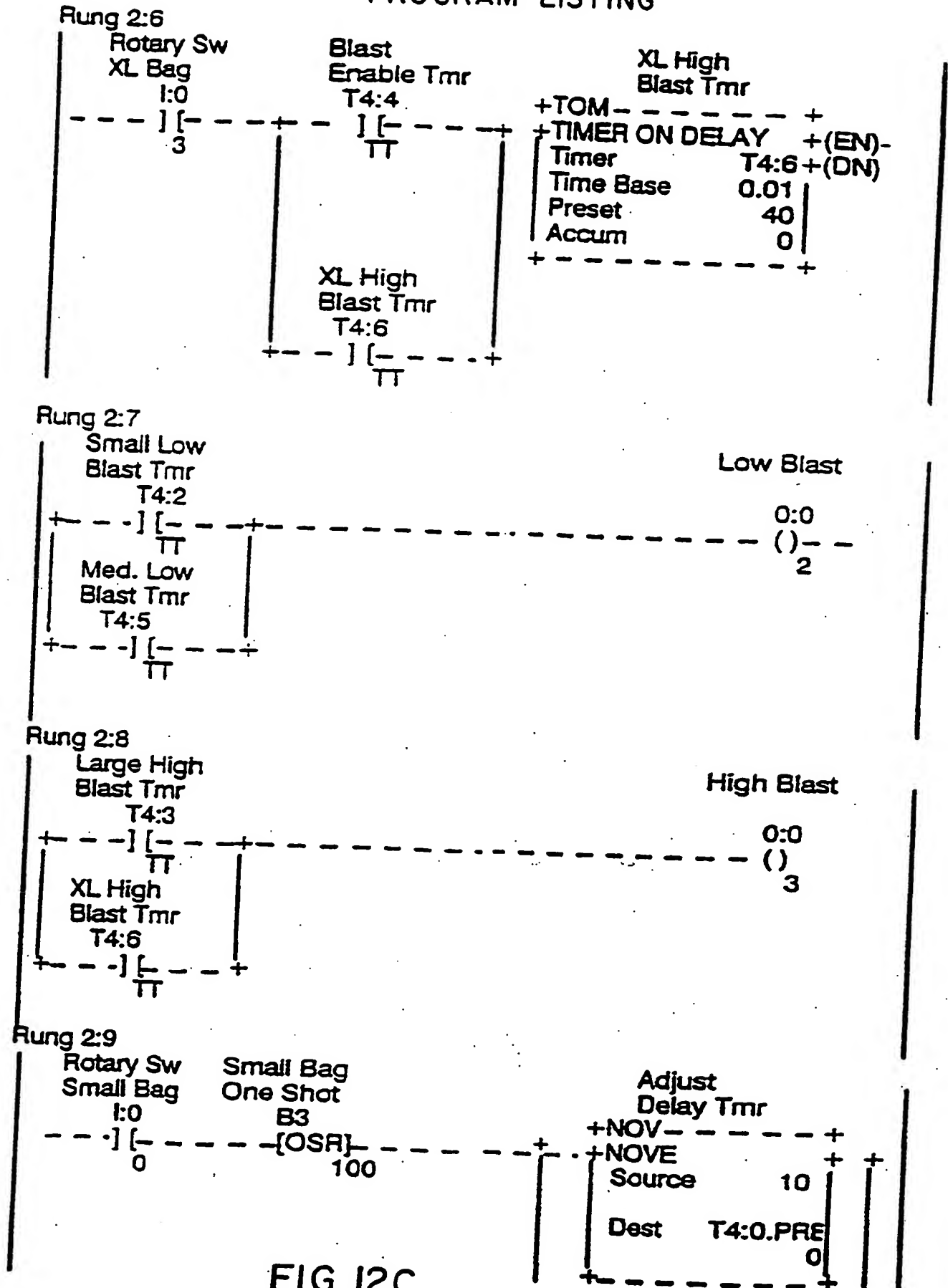


FIG. 12C

# AIR ASSISTED COLLATOR PROGRAM LISTING

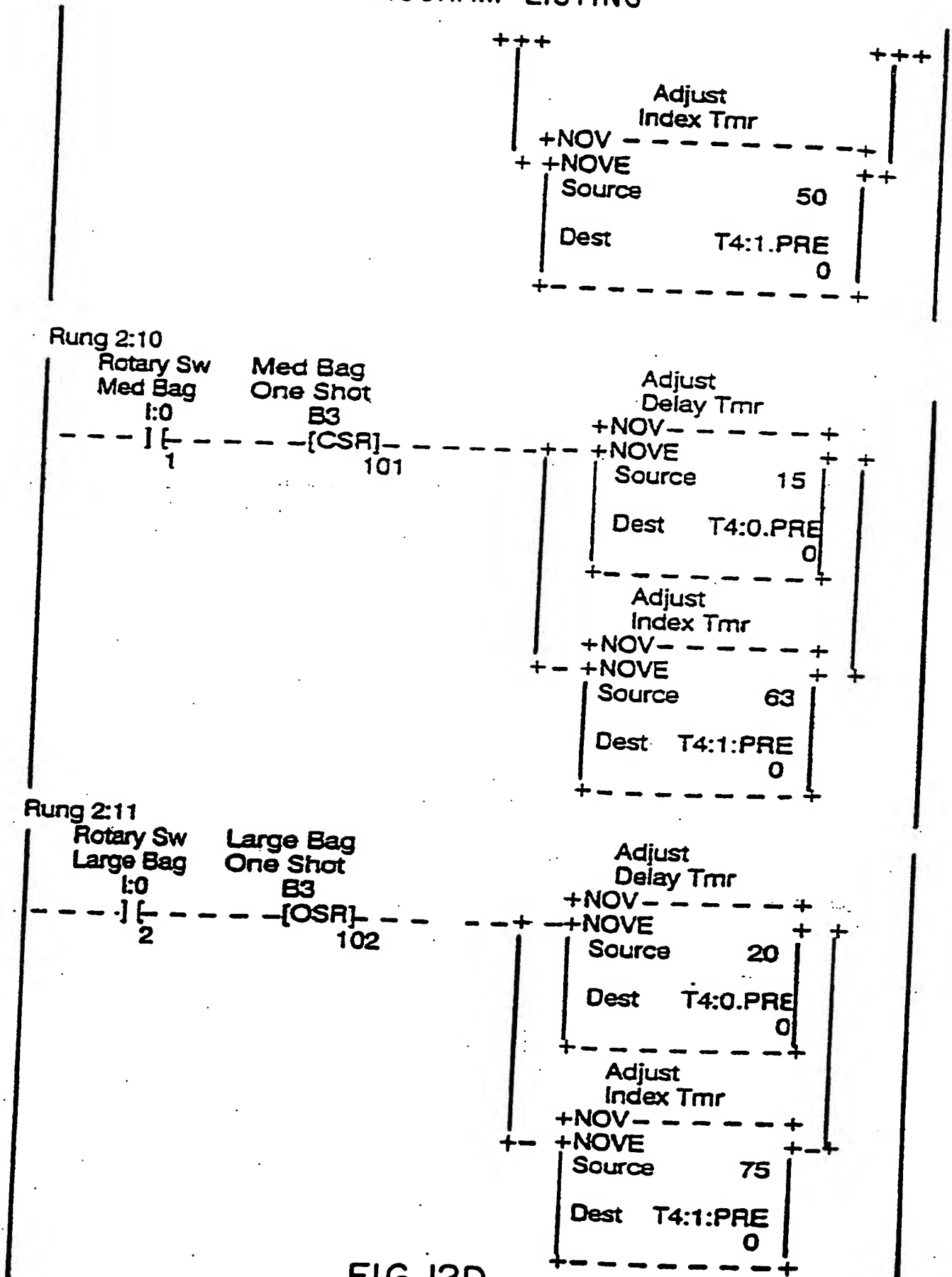
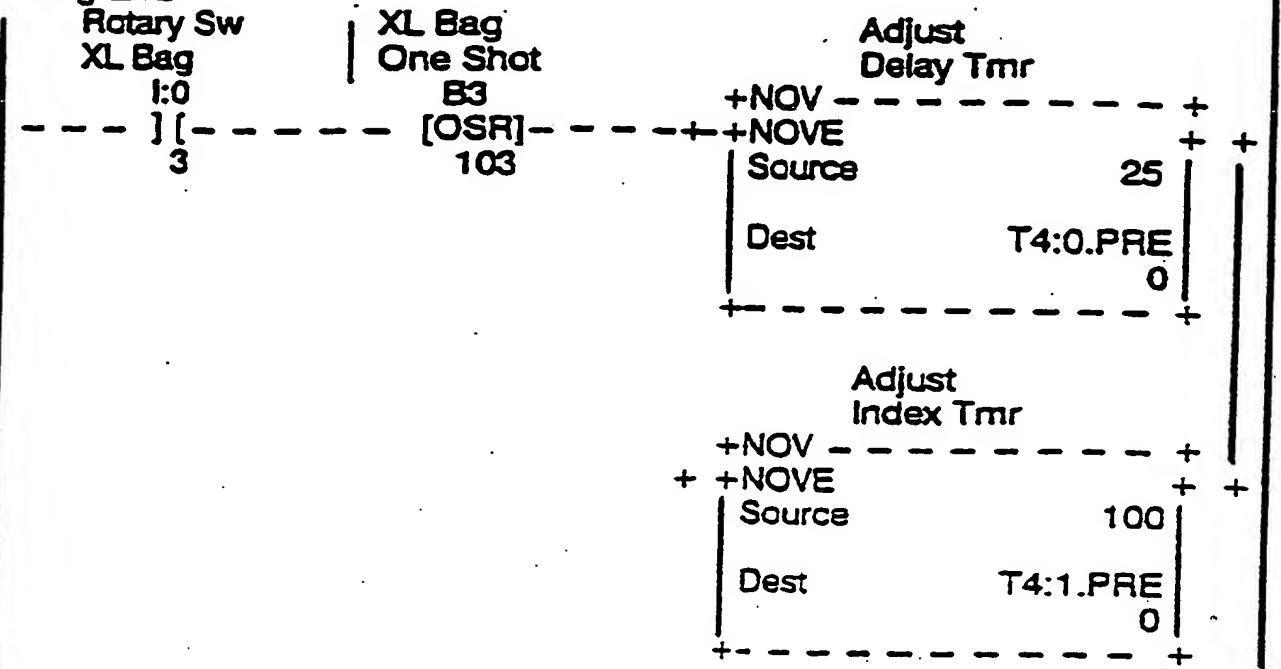


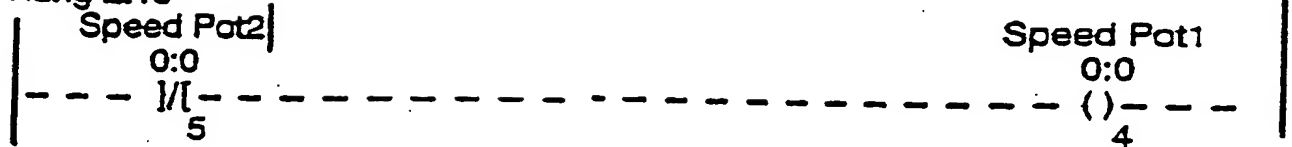
FIG 12D

# AIR ASSISTED COLLATOR PROGRAM LISTING

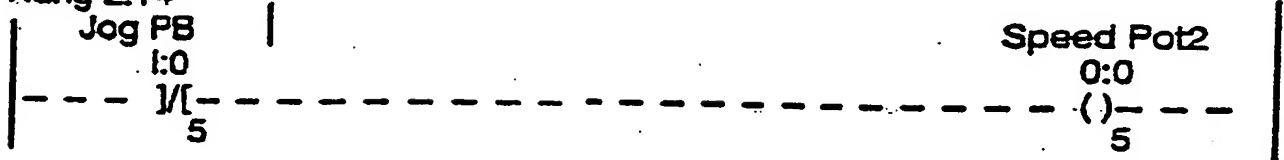
Rung 2:12



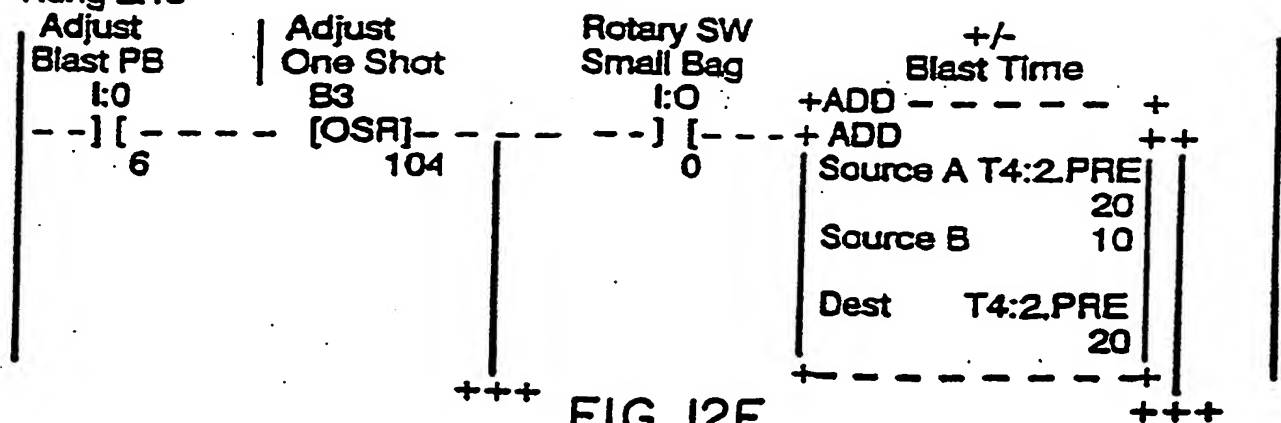
Rung 2:13



Rung 2:14



Rung 2:15

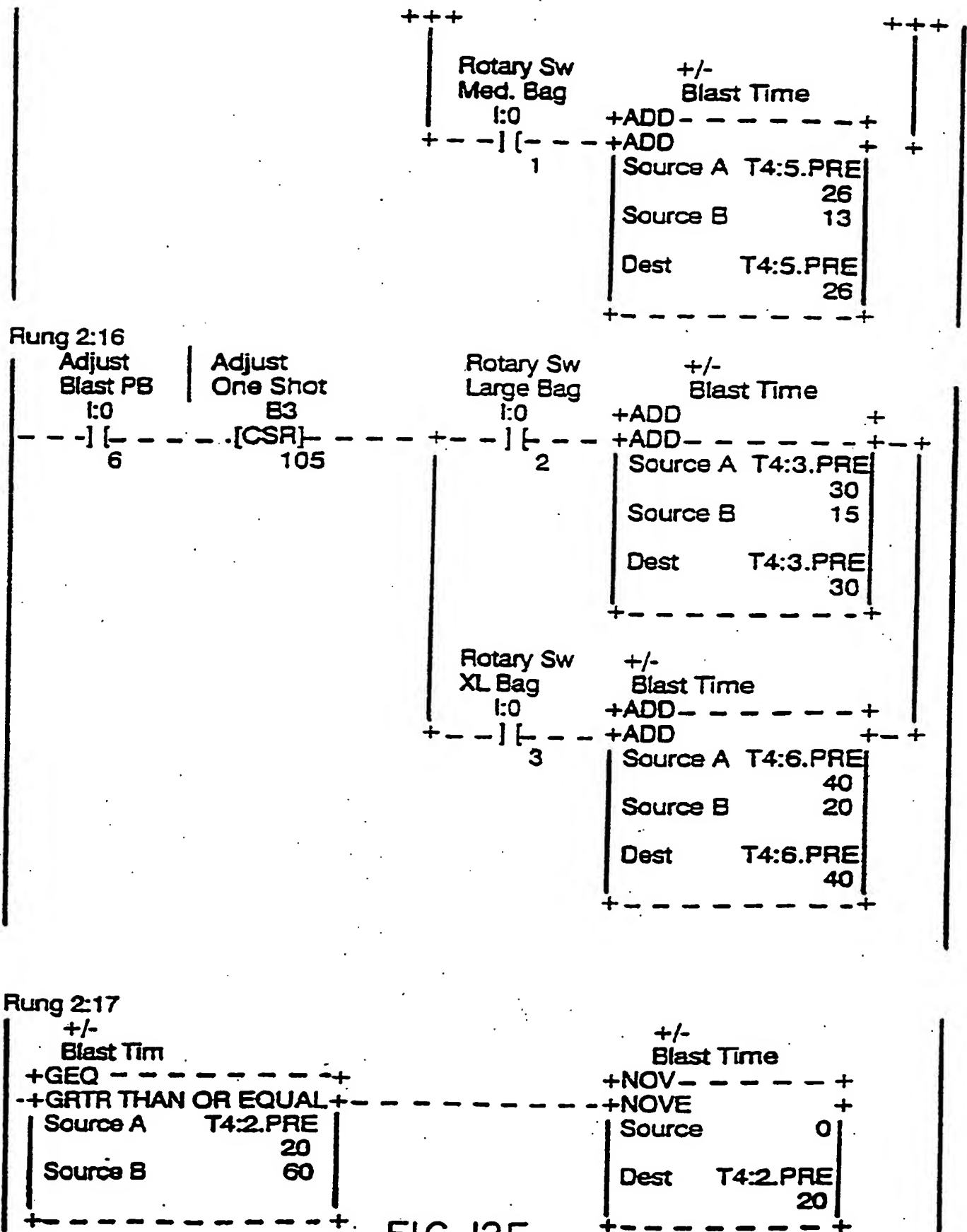


+++

FIG. 12F

+++

# AIR ASSISTED COLLATOR PROGRAM LISTING



# AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:18

+/- Blast Time		+/- Blast Time	
+GEQ	-----+	+NOV	-----+
+GRTR THAN OR EQUAL	+-----+	+NOVE	+-----+
Source A	T4:5.PRE	Source	0
	26	Dest	T4:5.PRE
Source B	78		26
+-----+		+-----+	

Rung 2:19

+/- Blast Time		+/- Blast Time	
+GEQ	-----+	+NOV	-----+
+GRTR THAN OR EQUAL	+-----+	+NOVE	+-----+
Source A	T4:3.PRE	Source	0
	30	Dest	T4:3.PRE
Source B	90		30
+-----+		+-----+	

Rung 2:20

+/- Blast Time		+/- Blast Time	
+GEQ	-----+	+NOV	-----+
+GRTR THAN OR EQUAL	+-----+	+NOVE	+-----+
Source A	T4:6.PRE	Source	0
	40	Dest	T4:6.PRE
Source B	120		40
+-----+		+-----+	

Rung 2:21

+-----+-----+-----+			
+END+			
+-----+-----+-----+			

FIG. 12G

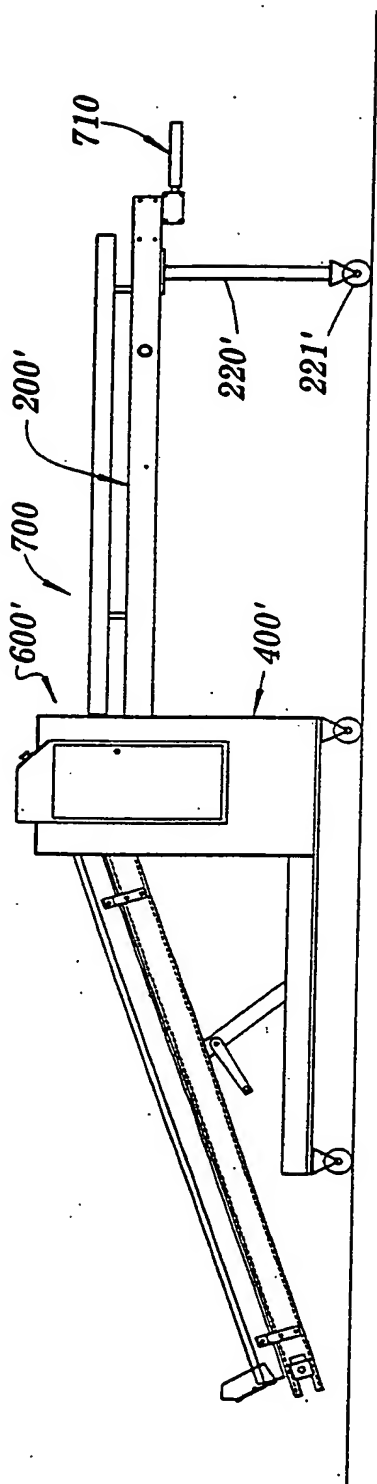


Fig. 13

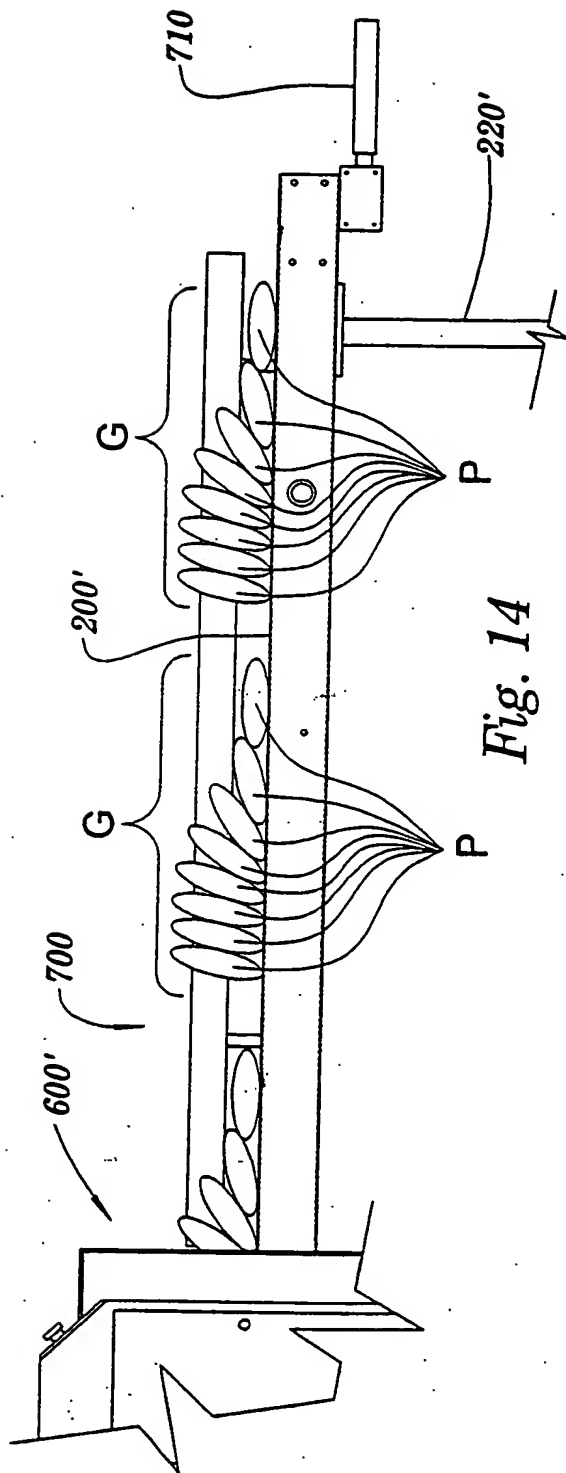


Fig. 14



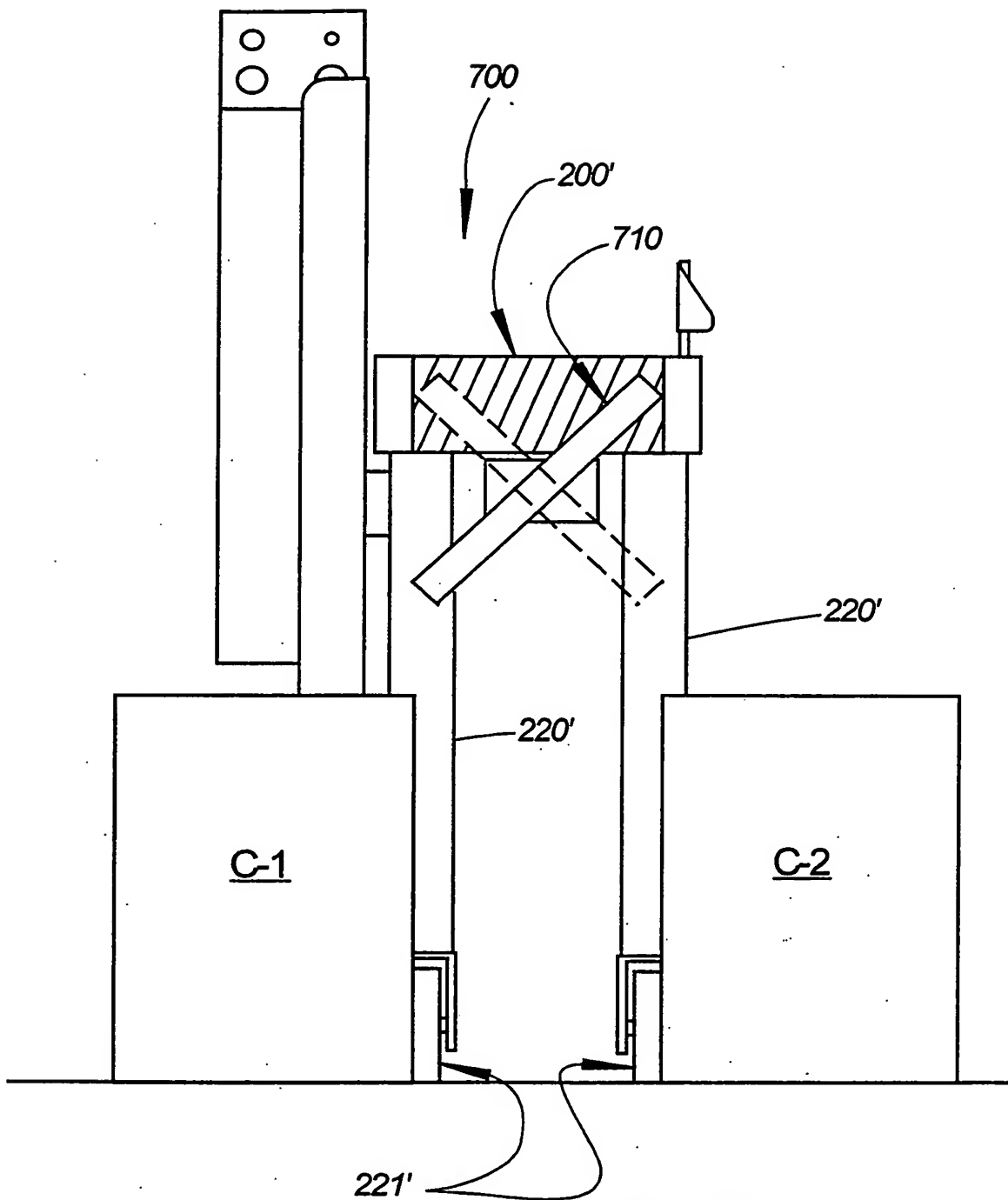


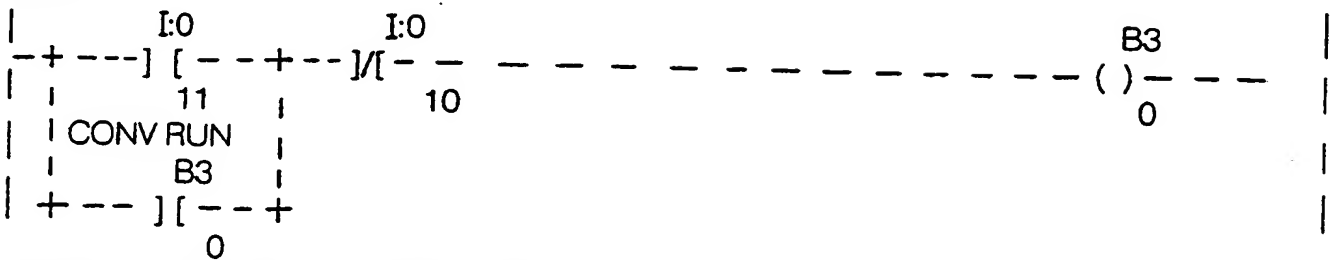
Fig. 15

RUNG 2:0 - START/STOP CONTROL.

RUNG 2:0 START PB E-STOP

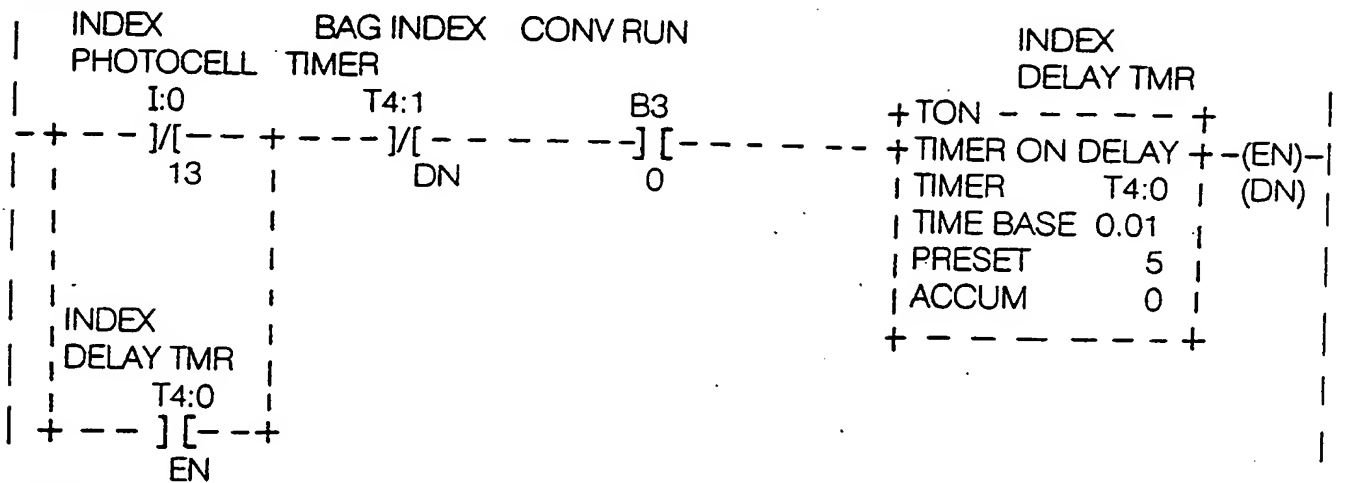
CONV

RUN

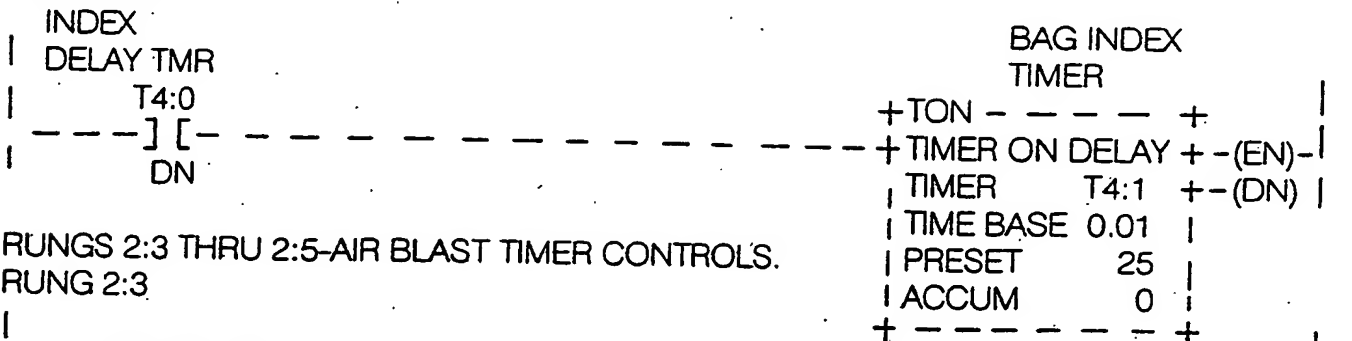


RUNG 2:1 AND 2:2 - INDEXING CONTROLS.

RUNG 2:1



RUNG 2:2



RUNGS 2:3 THRU 2:5-AIR BLAST TIMER CONTROLS.

RUNG 2:3

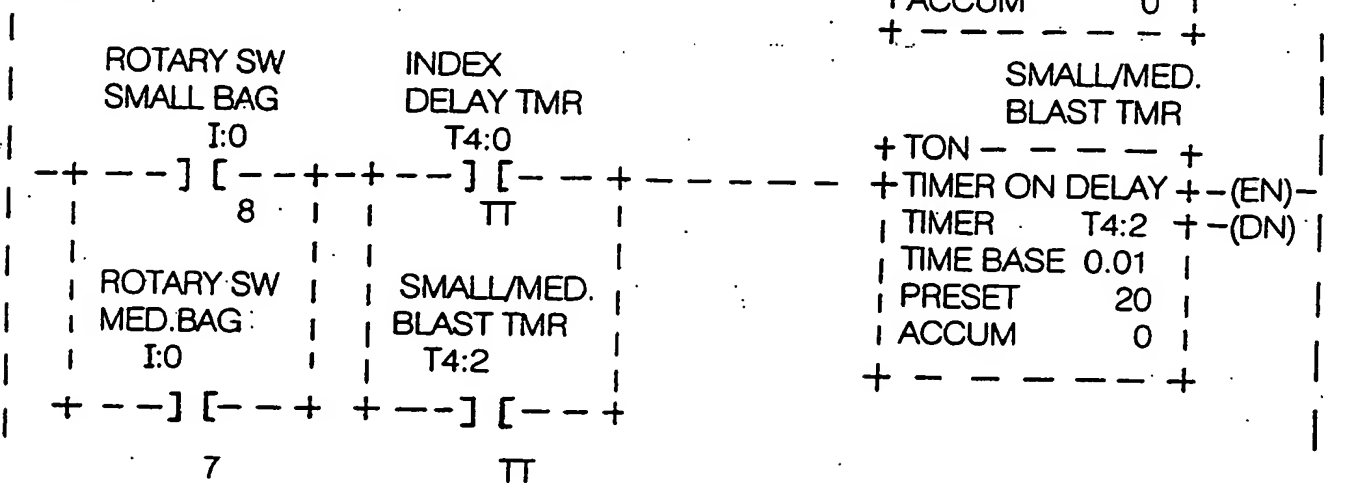


FIG.16A

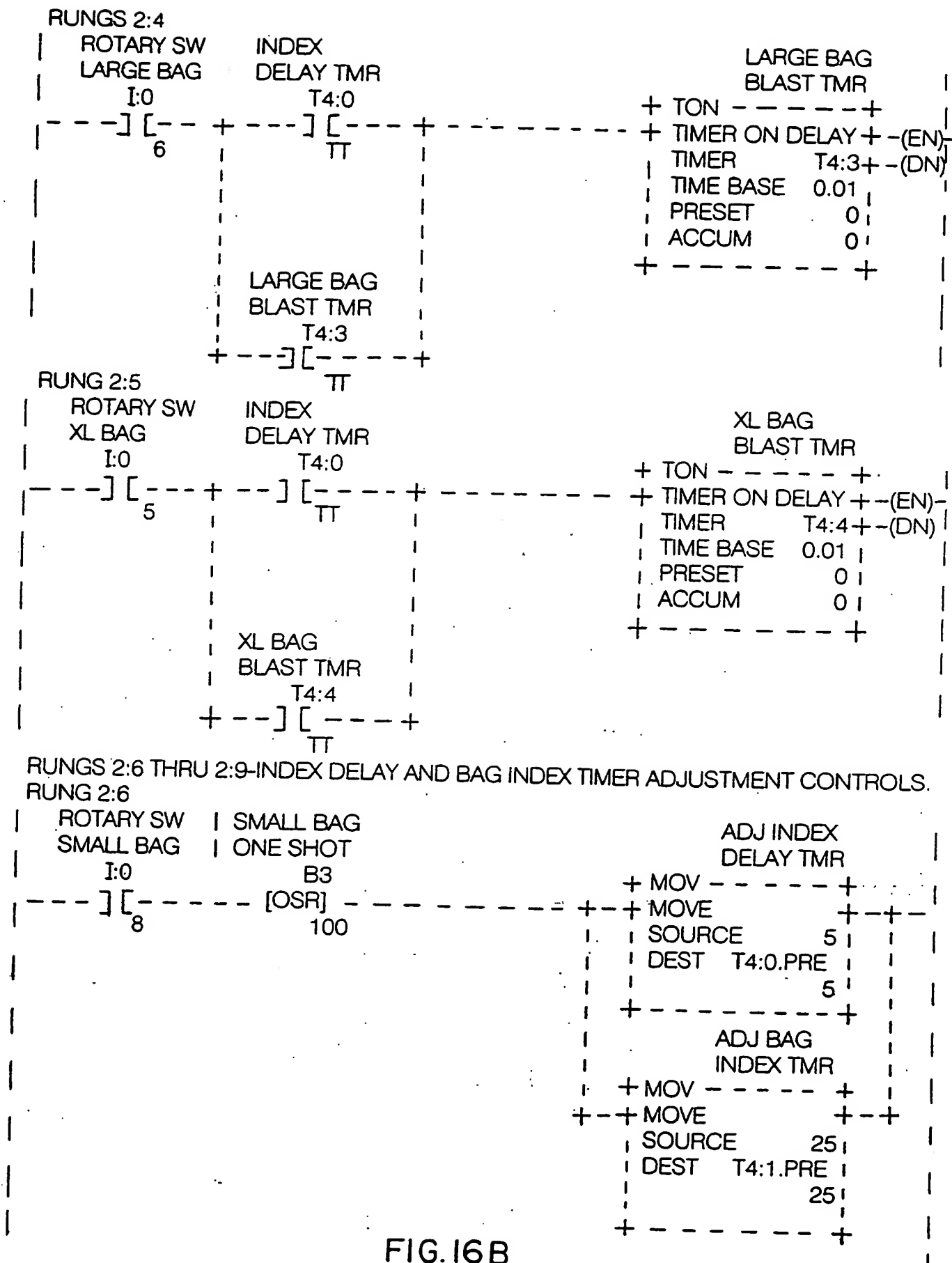
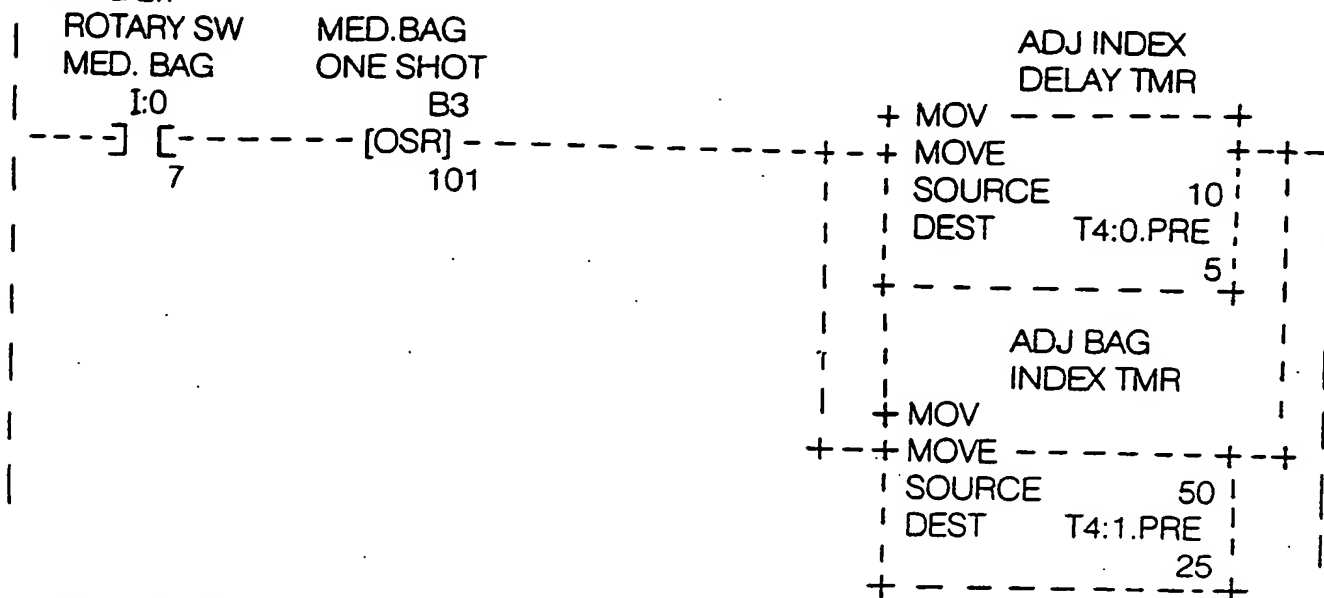


FIG.16B

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.

RUNG 2:7



RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.

RUNG 2:8

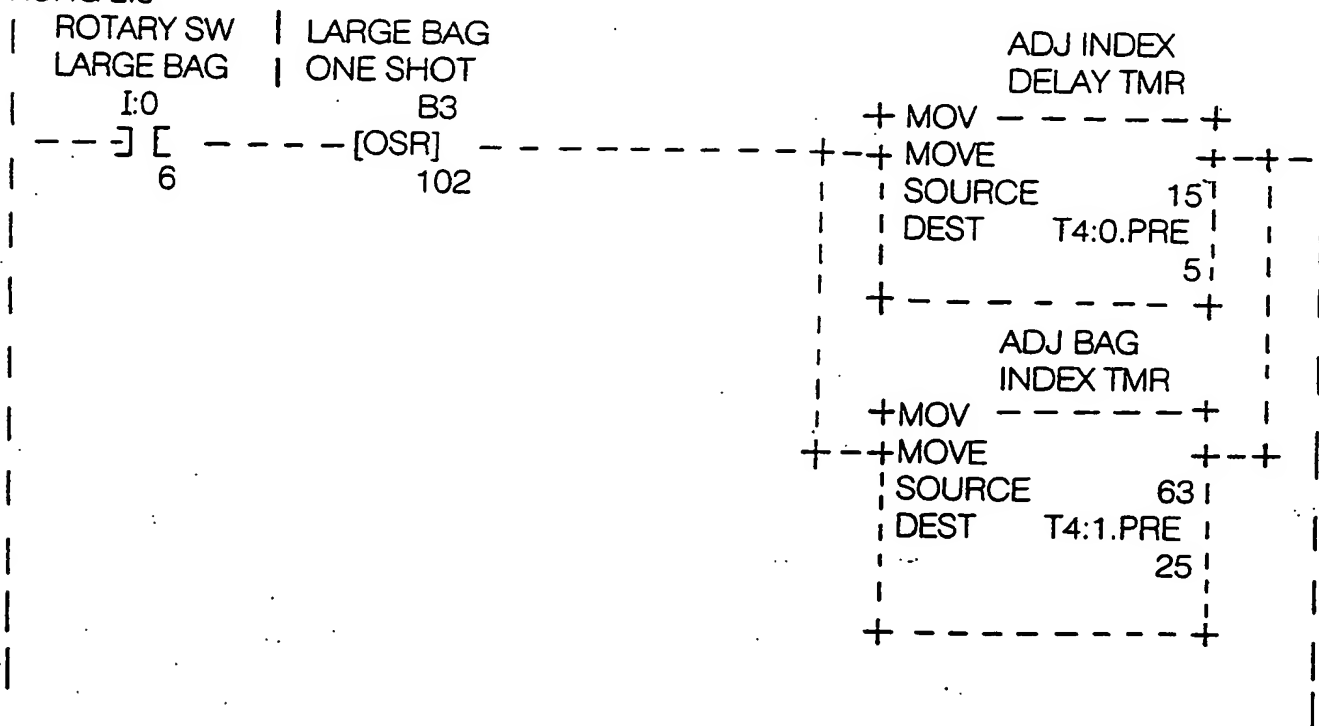


FIG. 16C

RUNG 2:9



RUNG 2:10



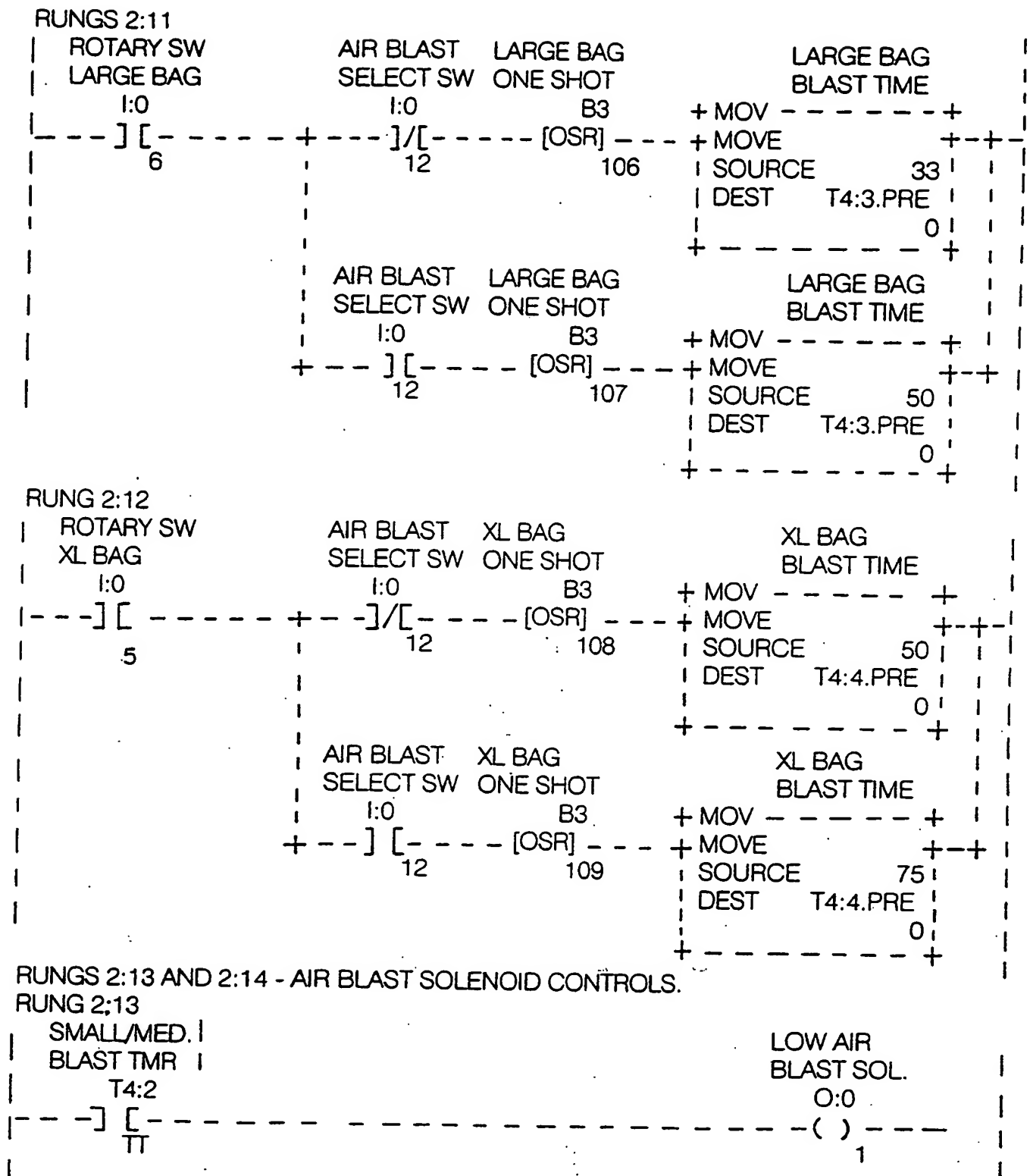
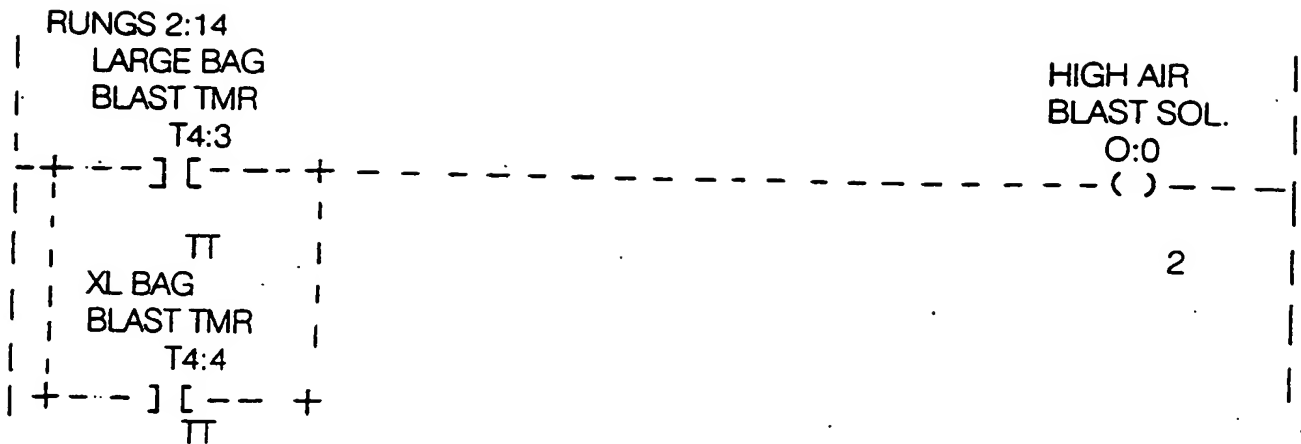


FIG. 16E



RUNGS 2:15 THRU 2:22 - DC MOTOR SPEED CONTROLS.

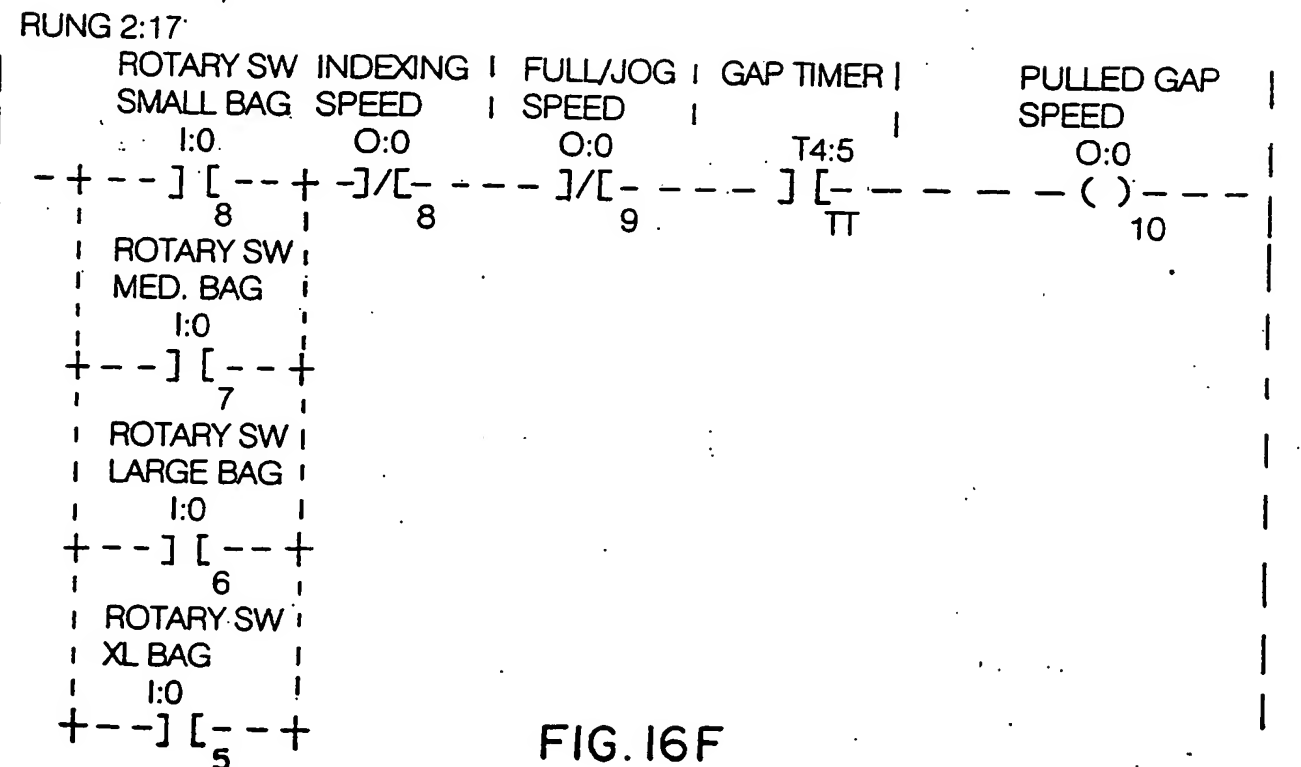
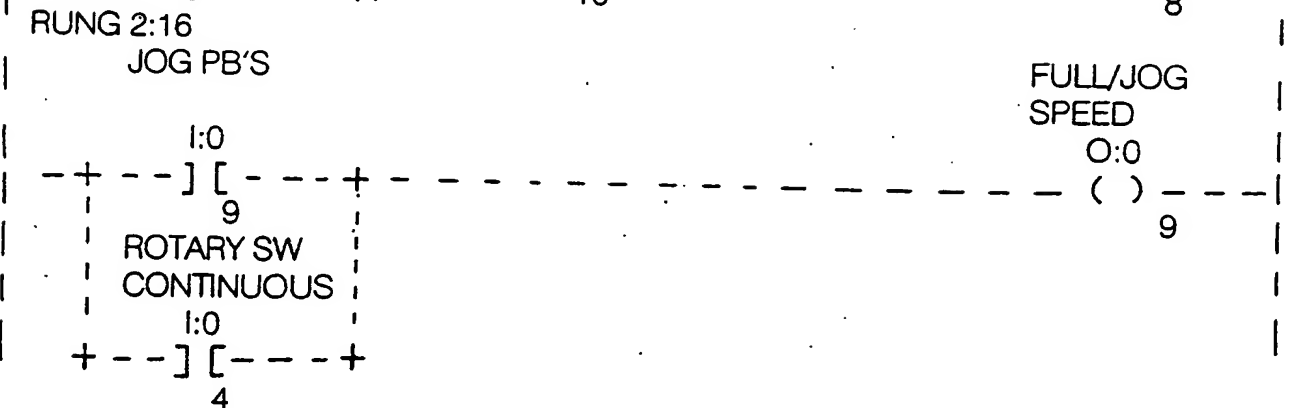
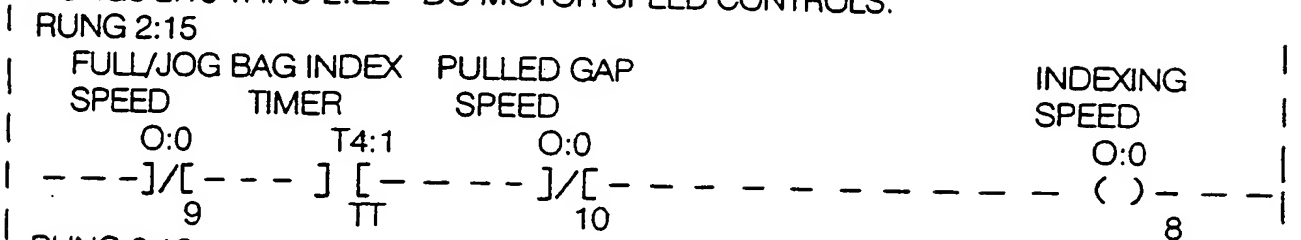


FIG. 16F

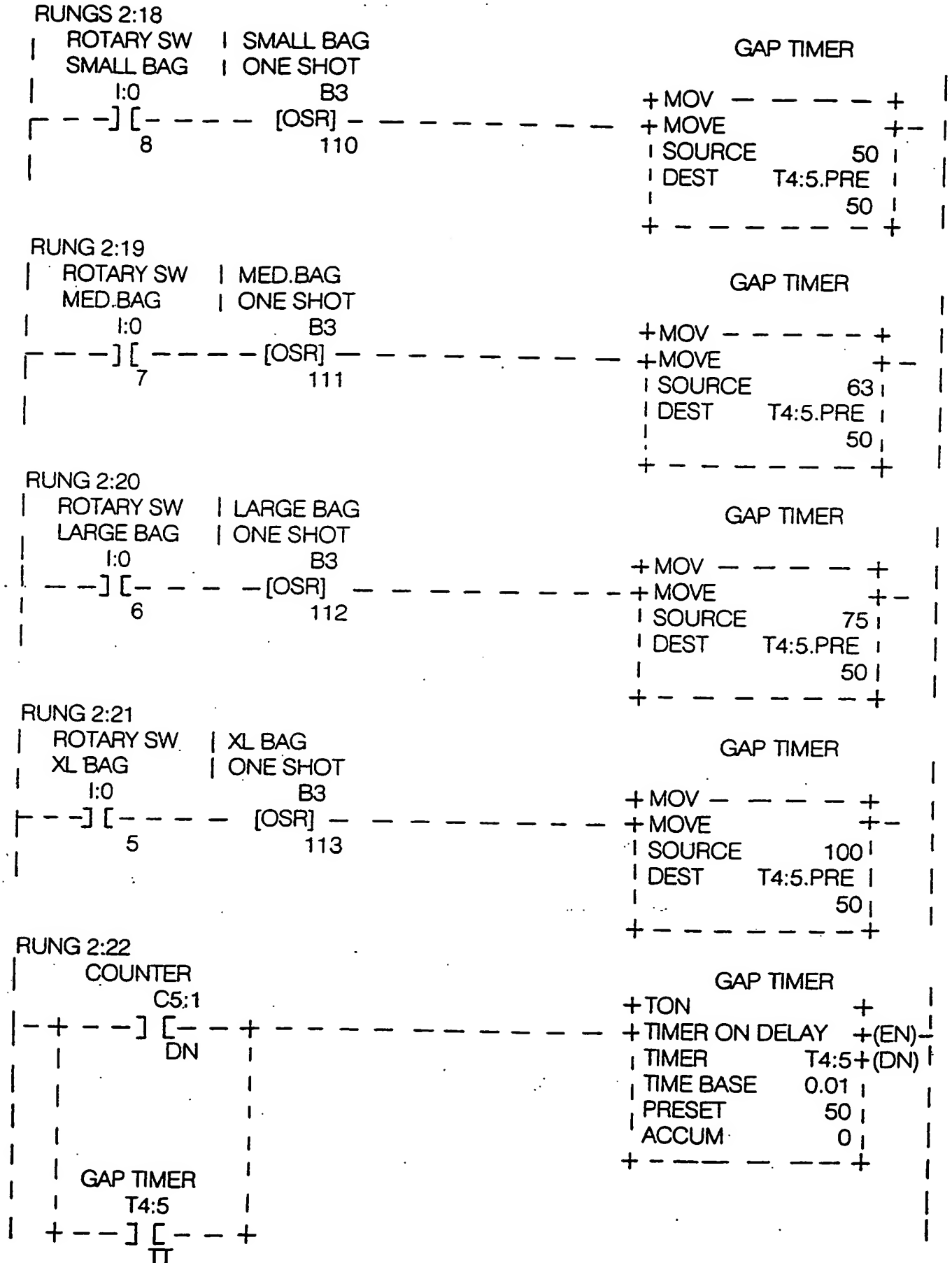
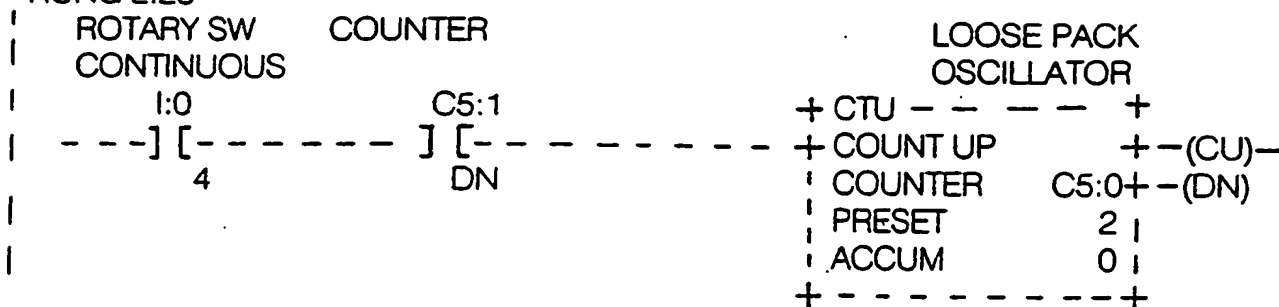


FIG. 16G

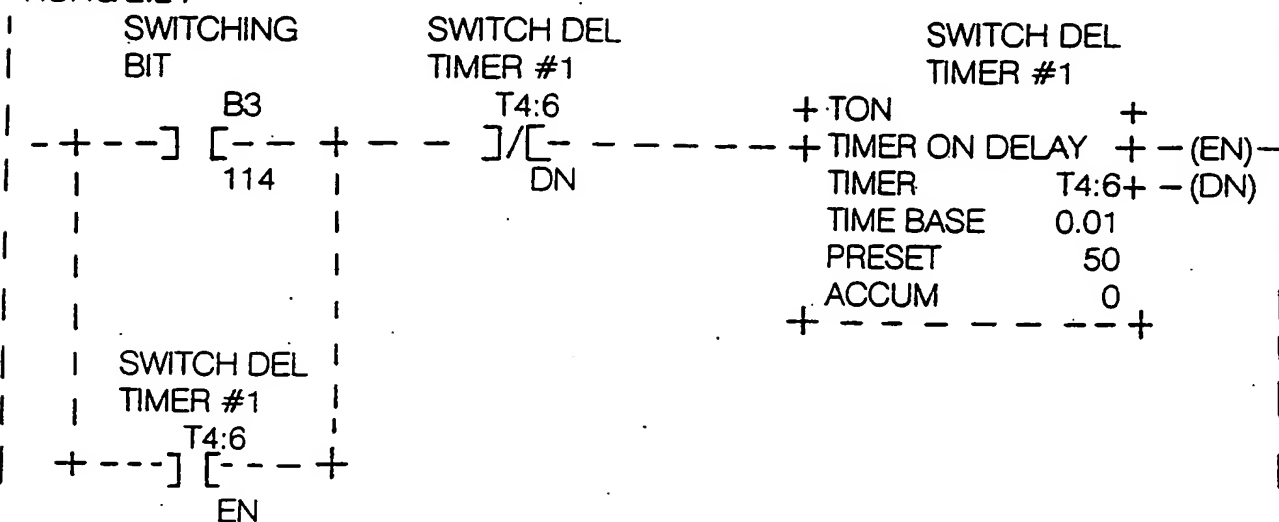


RUNGS 2:23 THRU 2:28 - OPTIONAL LOOSE PACK CONTROLS.

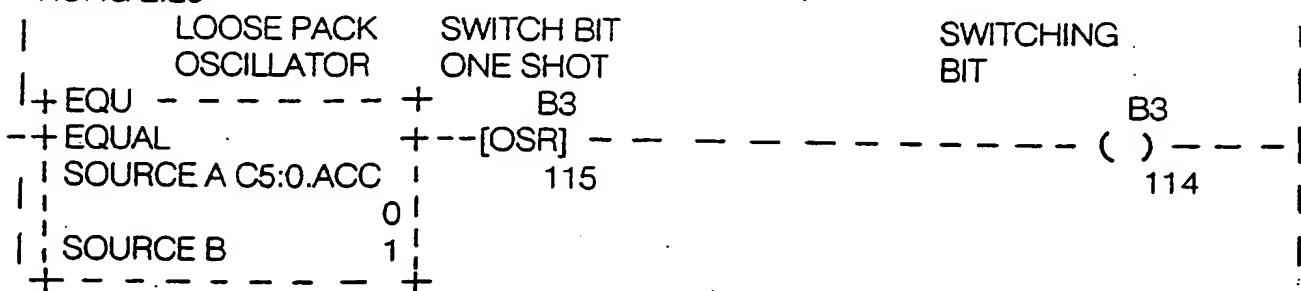
RUNG 2:23



RUNG 2:24



RUNG 2:25



RUNG 2:26

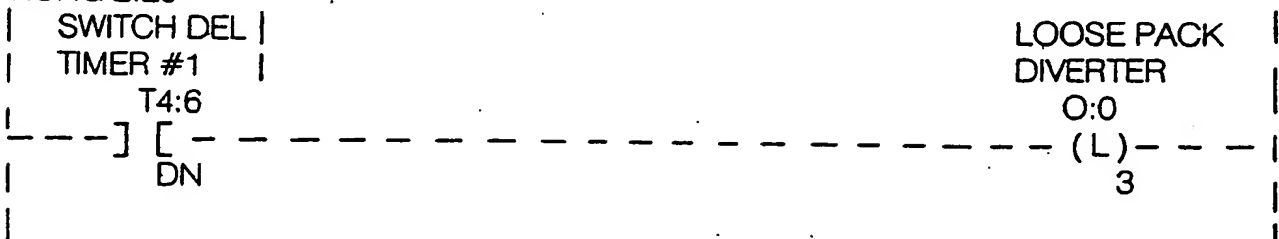


FIG. 16H

```

+-----+
|               |
| LOOSE PACK    |
| OSCILLATOR    |
|               |
+-----+
| + EQU - - - - - + |
| + EQUAL - - - - - + |
| | SOURCE A C5:0.ACC | |
| | | 0 |
| | SOURCE B | 2 |
| | | 0 |
| + - - - - - + |
| |
| SWITCH DEL    |
| TIMER #2      |
| T4:7          |
| + - - - - - + |
| |
| ] [ - - - - - + |
| |
| EN            |
|               |
+-----+
|               |
| SWITCH DEL    |
| TIMER #2      |
| T4:7          |
| + - - - - - + |
| |
| ] [ - - - - - + |
| |
| EN            |
|               |
+-----+

```

SWITCH DEL I  
TIMER #2 I  
T4:7  
-- ] [ --  
DN  
LOOSE PACK  
DIVERTER  
O:0  
(U)  
3

RUNG 2:29

START PB | START PB | | START

| ONE SHOT |

I:0 B3

-----] [-----[OSR]----- ( )-----

11 20 21

FIG. 16I

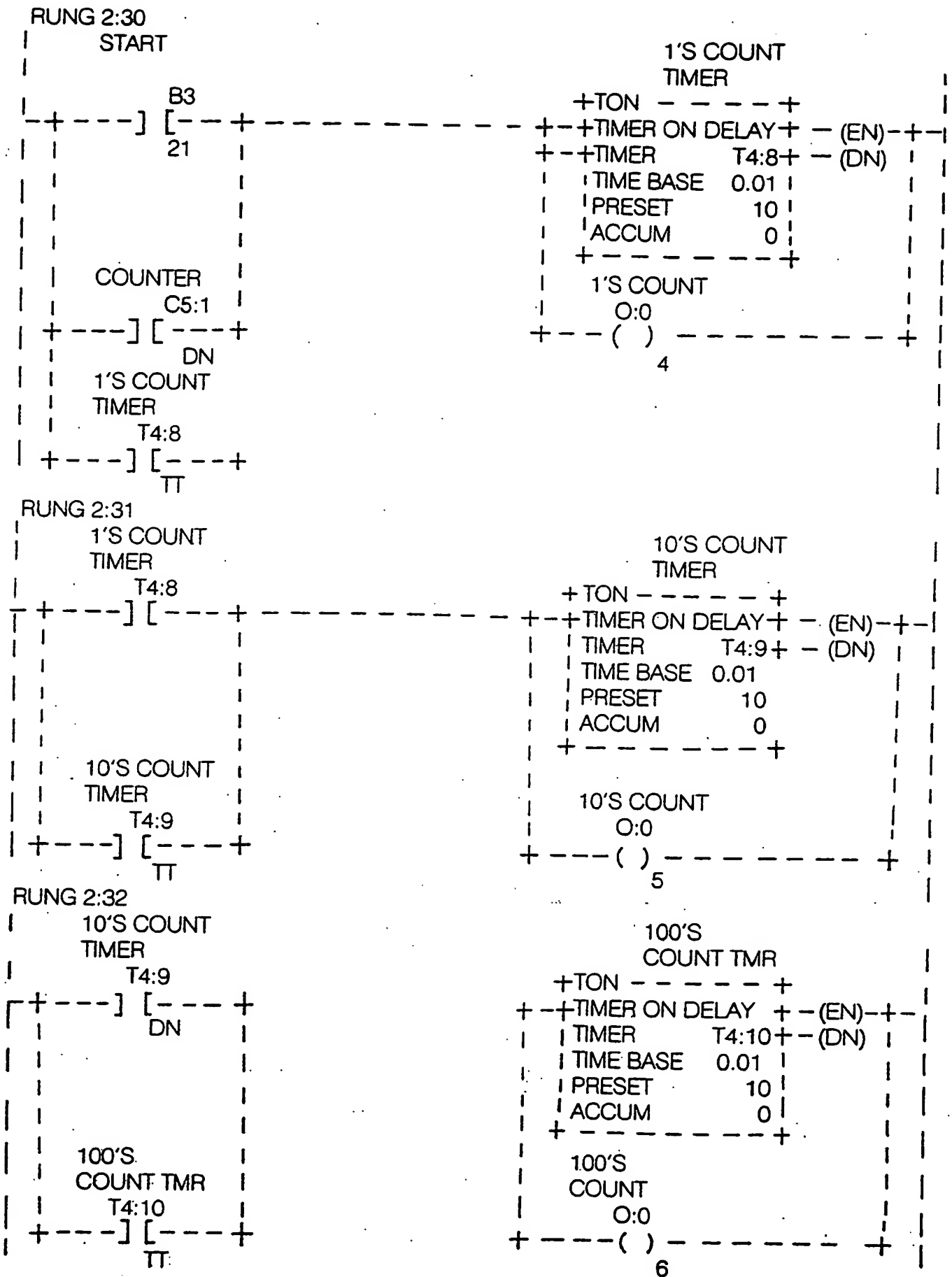
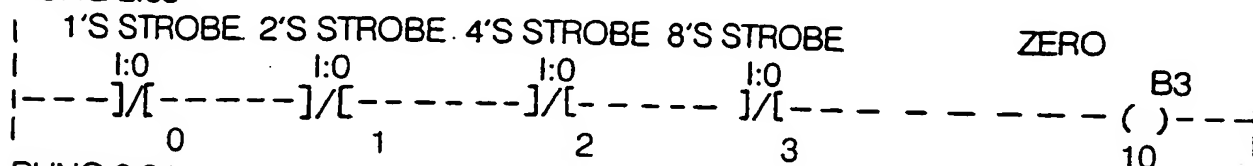


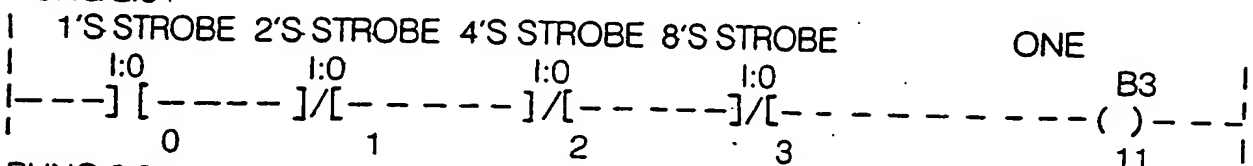
FIG. 16J

RUNGS 2:33 THRU 2:42-NUMBER CONTROL FOR ALL THUMBWHEEL SWITCHES.

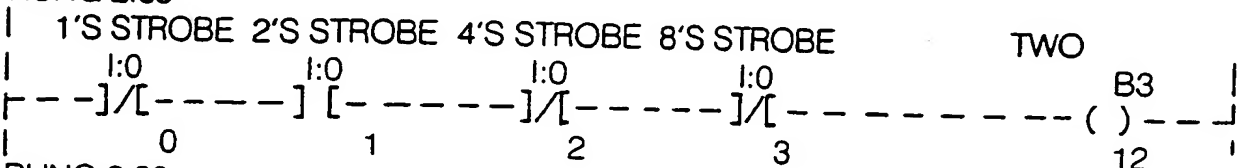
RUNG 2:33



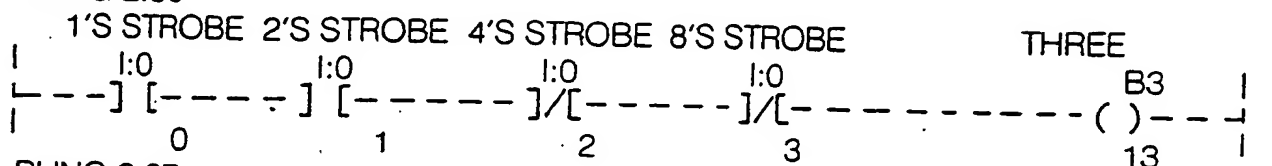
RUNG 2:34



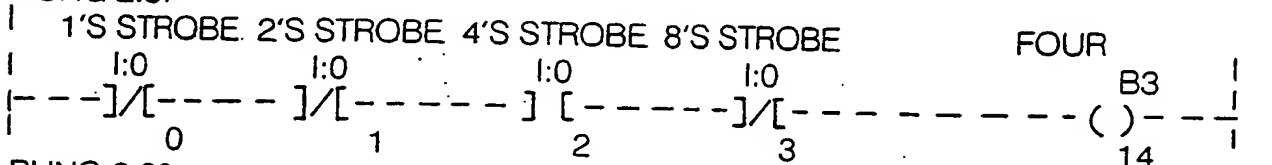
RUNG 2:35



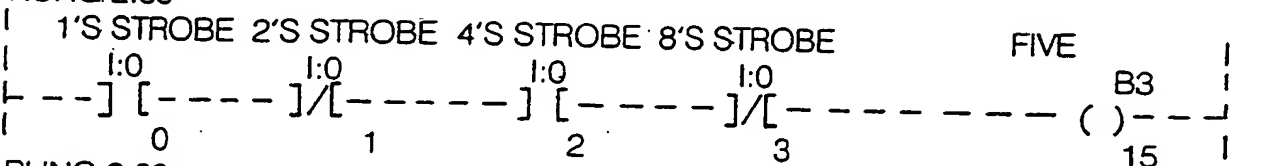
RUNG 2:36



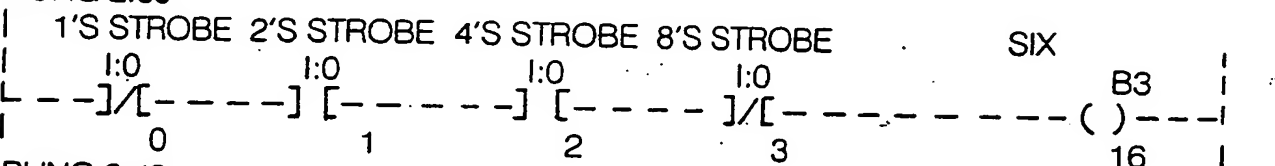
RUNG 2:37



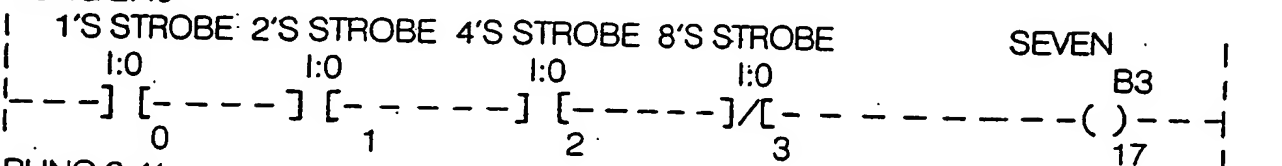
RUNG 2:38



RUNG 2:39



RUNG 2:40



RUNG 2:41

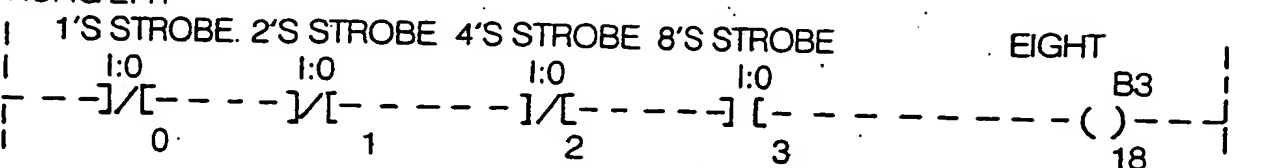


FIG. 16K

1'S STROBE 2'S STROBE 4'S STROBE 8'S STROBE NINE B3

1 0 1 2 3 ( ) 19

RUNG 2:43

[illegible]

FIG. 16L

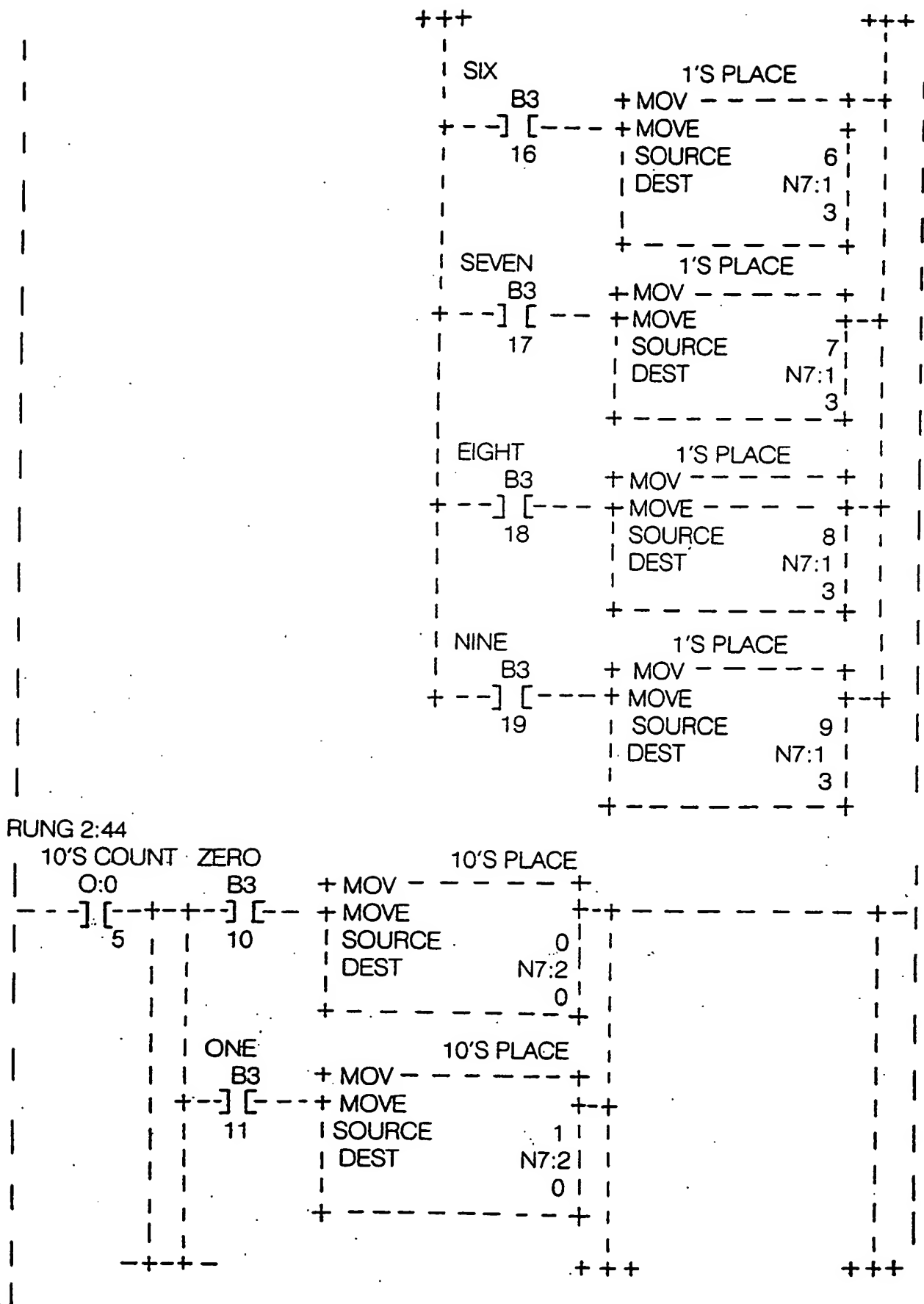


FIG. 16M

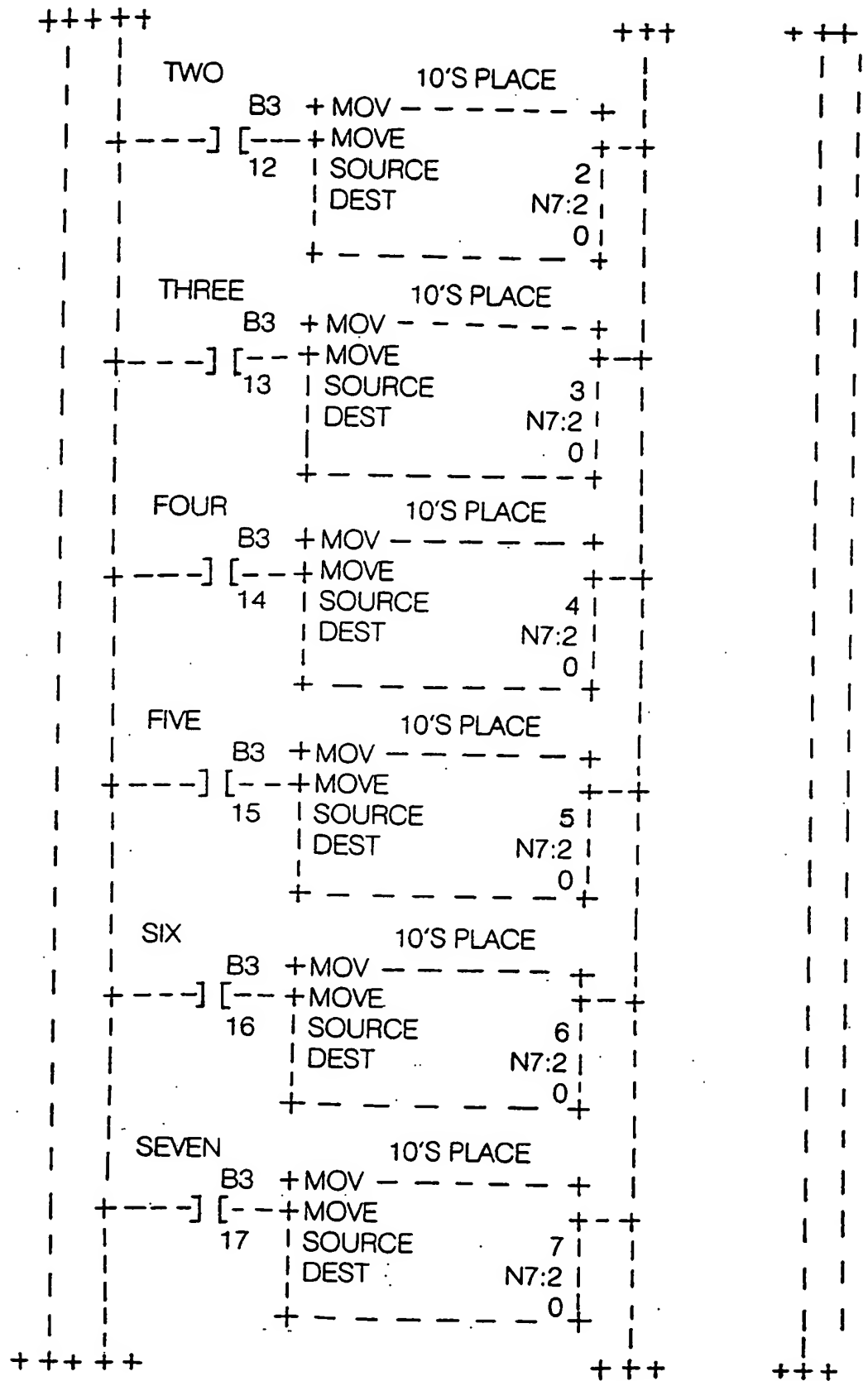


FIG. 16N





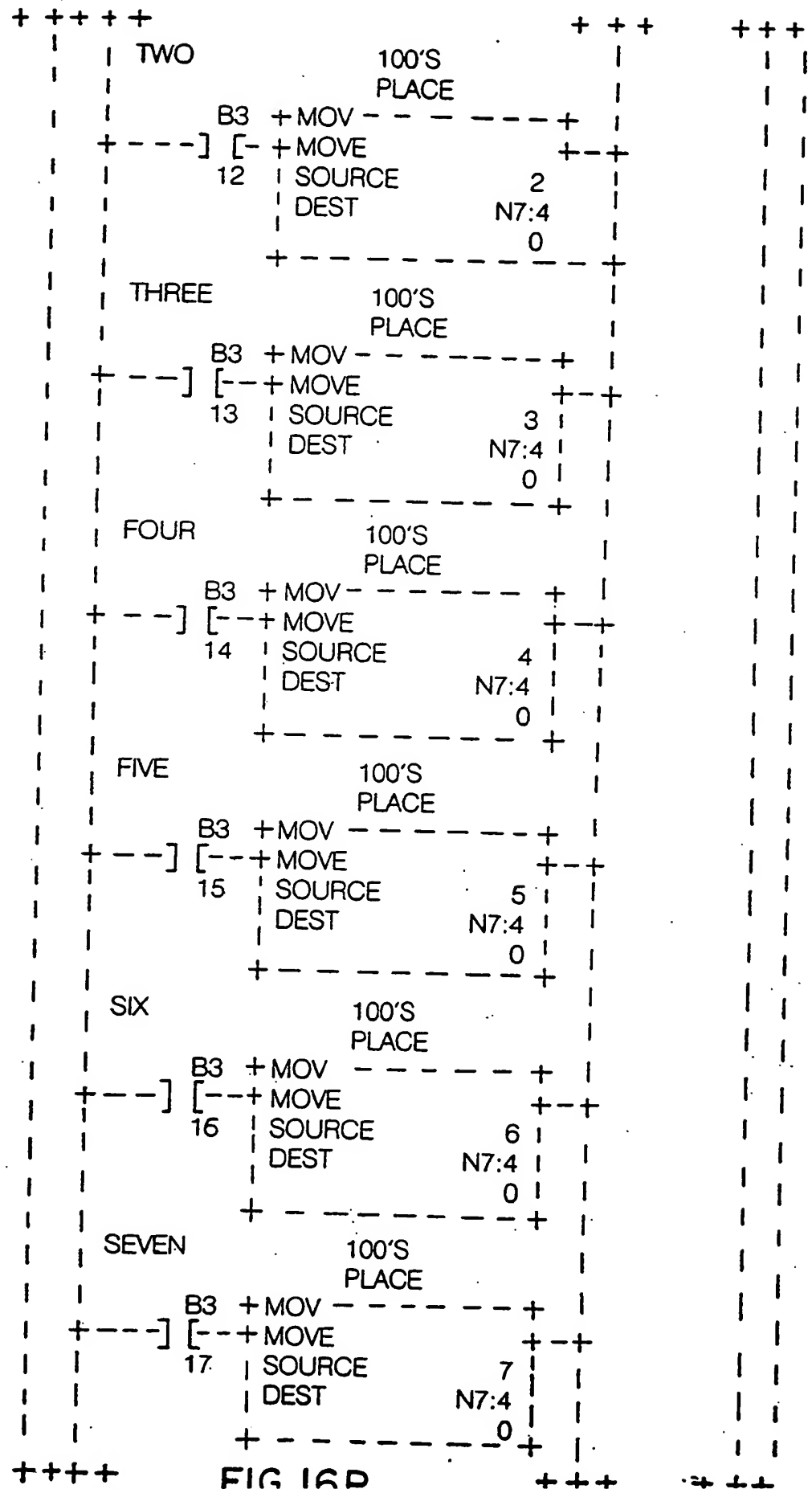


FIG 16D

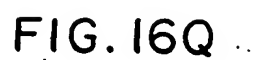


FIG. 16Q

RUNG 2:47

100'S  
COUNT TMR

T4:10

DN

ADD TOTAL  
TO 100'S

```

+ ADD - - - - - +
+ ADD
SOURCE A      N7:6 |
3 |
SOURCE B      N7:4 |
0 |
DEST          N7:0 |
+ - - - - - 3 +
+ MOV - - - - - +
+ MOVE
SOURCE        N7:0 |
DEST          C5:1.PRE |
3 |
+ - - - - - +

```

RUNGS 2:48 THRU 2:50 COUNTER CONTROLS.  
THE COUNTER IS RESET EVERY TIME IT  
REACHES IT'S COUNT, AND RELOADS THE  
THUMBWHEEL VALUE. THIS HAPPENS ALSO  
WHEN THE START BUTTON IS PRESSED.

RUNG 2:48

ADD TOTAL  
TO 100'S

```

+ EQ - - - - - +
+ EQUAL
SOURCE A      N7:0 |
3 |
SOURCE B      0 |
+ - - - - - +

```

COUNT SET AT ZERO

B3

1

RUNG 2:49

COUNTER

C5:1

DN

START PB

I:0

11

COUNTER

C5:1

(RES)

RUNG 2:50

INDEX      ROTARY SW    COUNT SET CONV RUN COUNTER    COUNTER  
PHOTOCELL CONTINUOUS    AT ZERO      ONE SHOT

```

I:0      I:0      B3      B3      B3 + CTU - - - - - +
+ - - - ]/[ - - - ]/[ - - - + - - ]/[ - - - ] - - [OSR] - + COUNT UP    + - (CU) -
13      4      1      0      116 | COUNTER C5:1 + - (DN)
|      |      |      |      | |
|      |      |      |      | PRESET      3 |
|      |      |      |      | ACCUM      0 |
+ - - - - - +
LOOSE PACK | ROTARY SW
PHOTOCELL | CONTINUOUS
I:0      I:0
+ - - - ]/[ - - - ]/[ - - - +
14      4

```

FIG.16R

RUNG 2:51



120VAC, 1 Ph, 60 Hz  
25 AMP POWER CORD

OPTIONAL DISCONNECT  
SWITCH 30 AMP

DUPLEX  
RECEPTACLE

KB DC DRIVE

VFD

PLC PWR SUPPLY

RELNUM

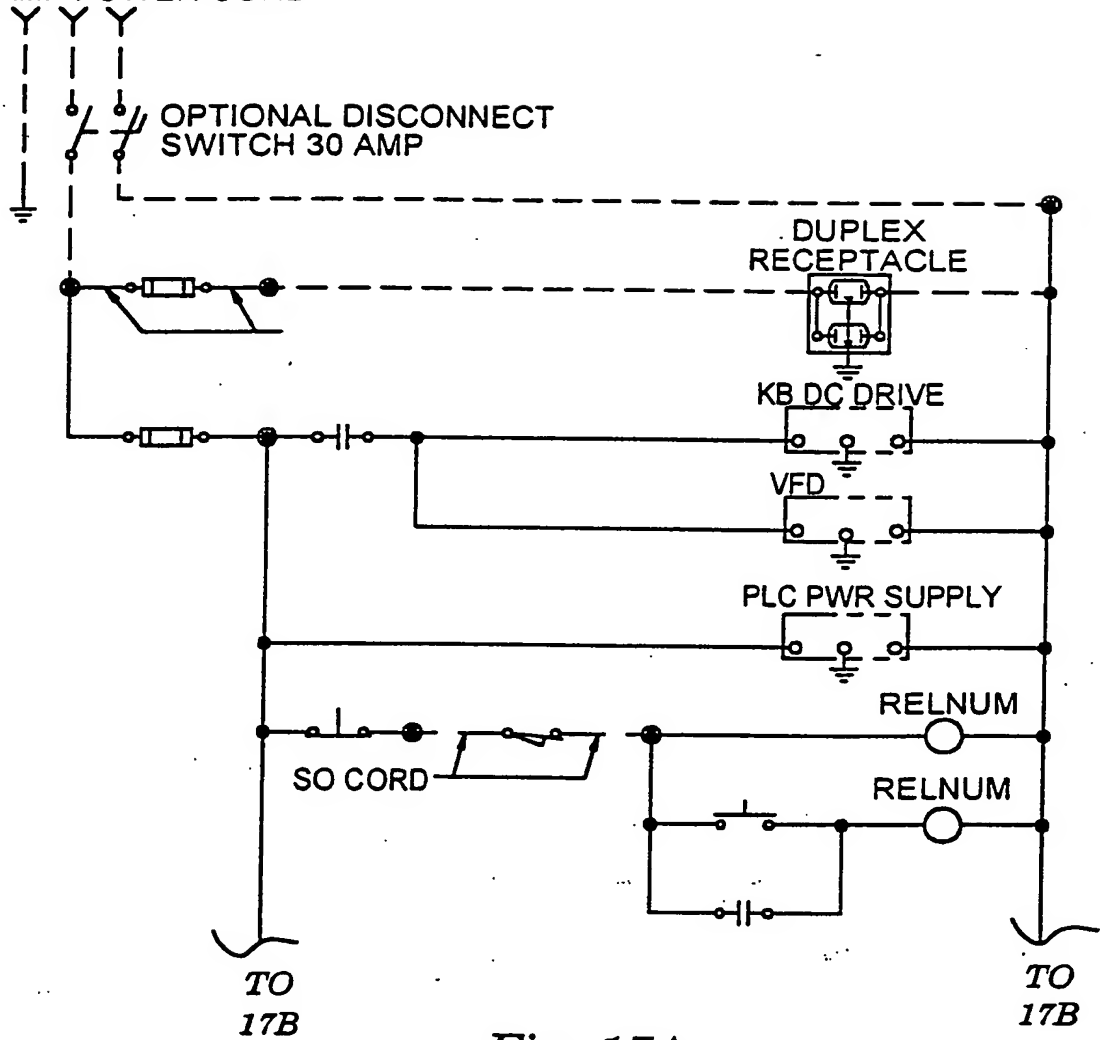
RELNUM

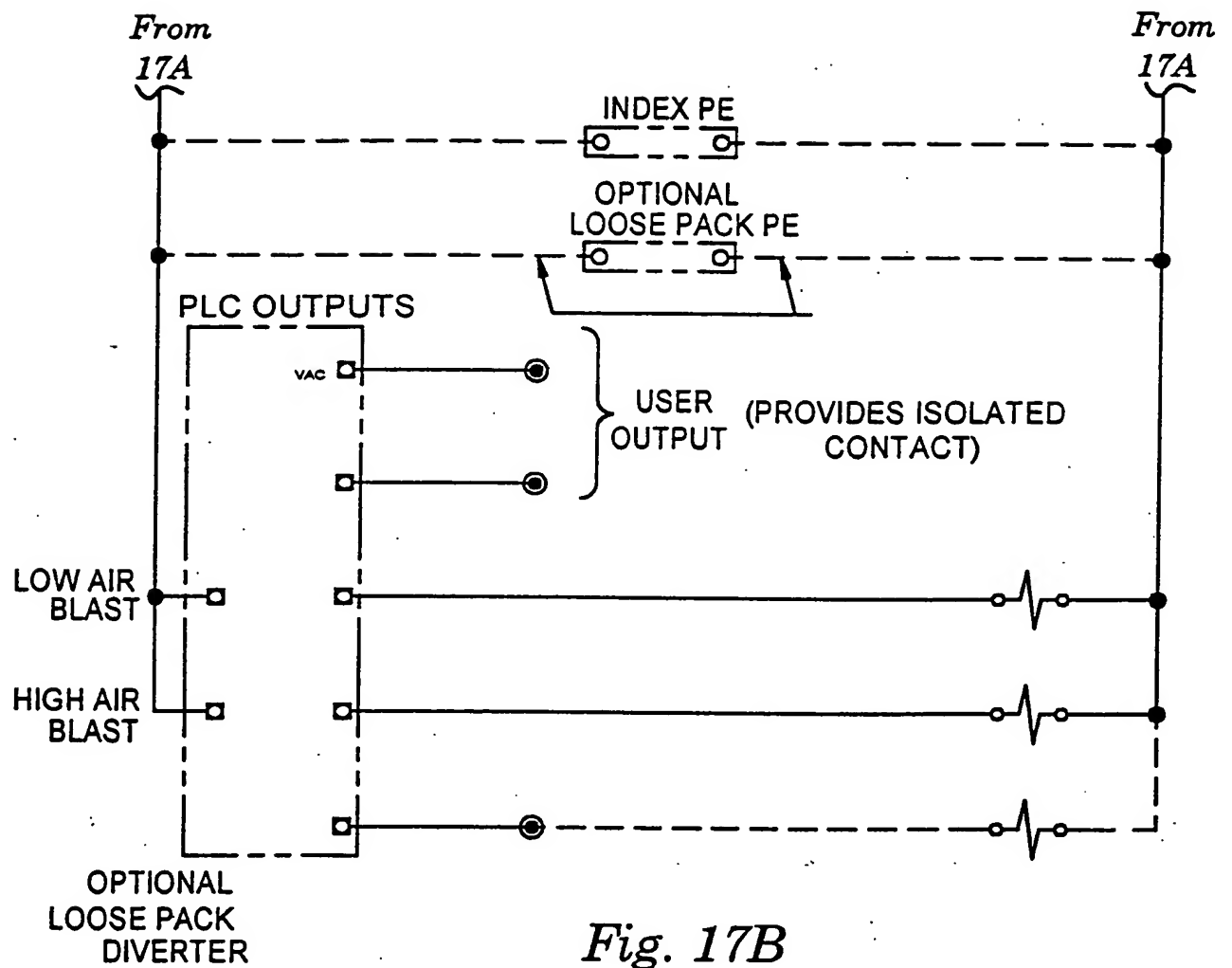
SO CORD

TO  
17B

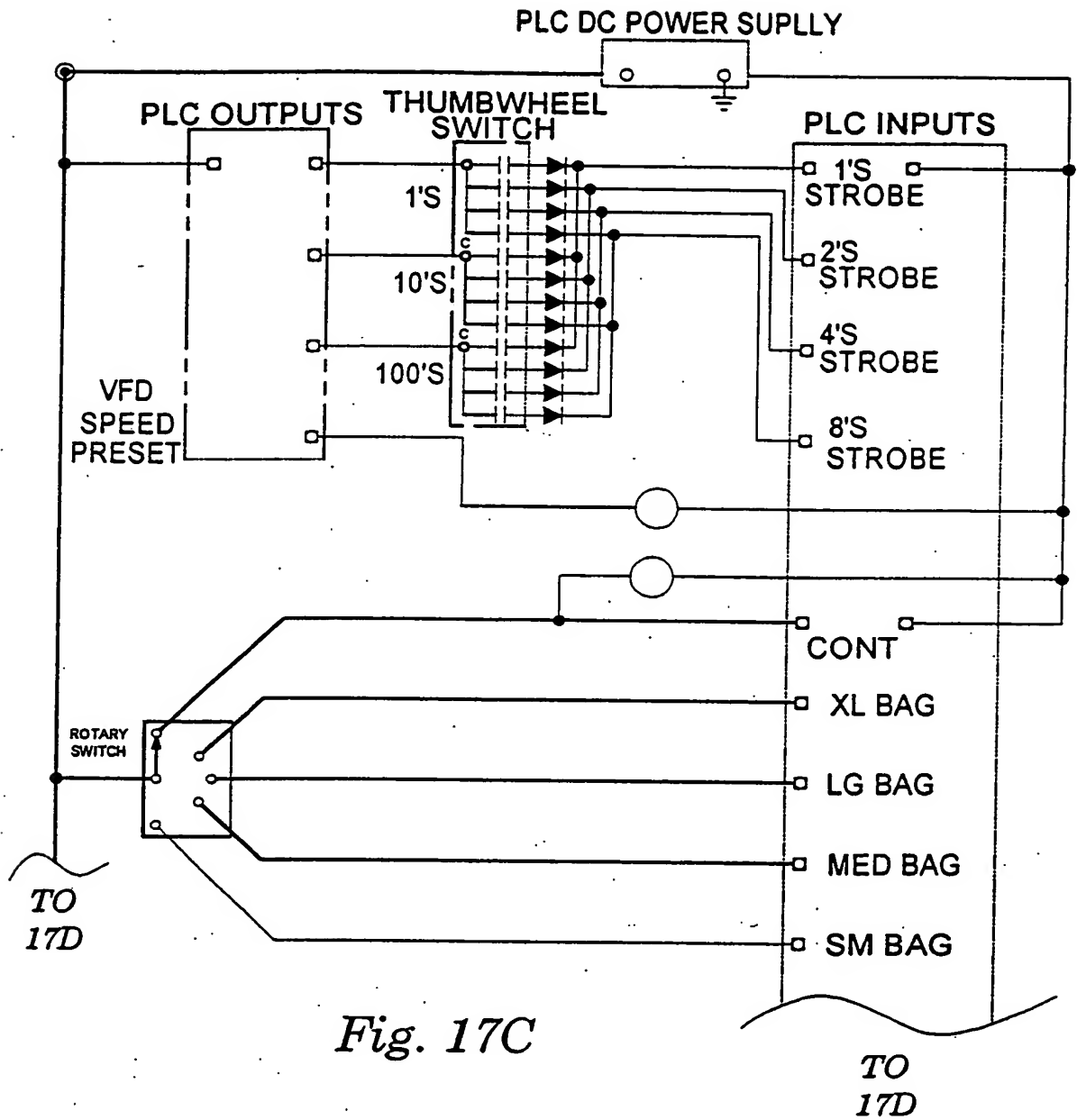
TO  
17B

Fig. 17A

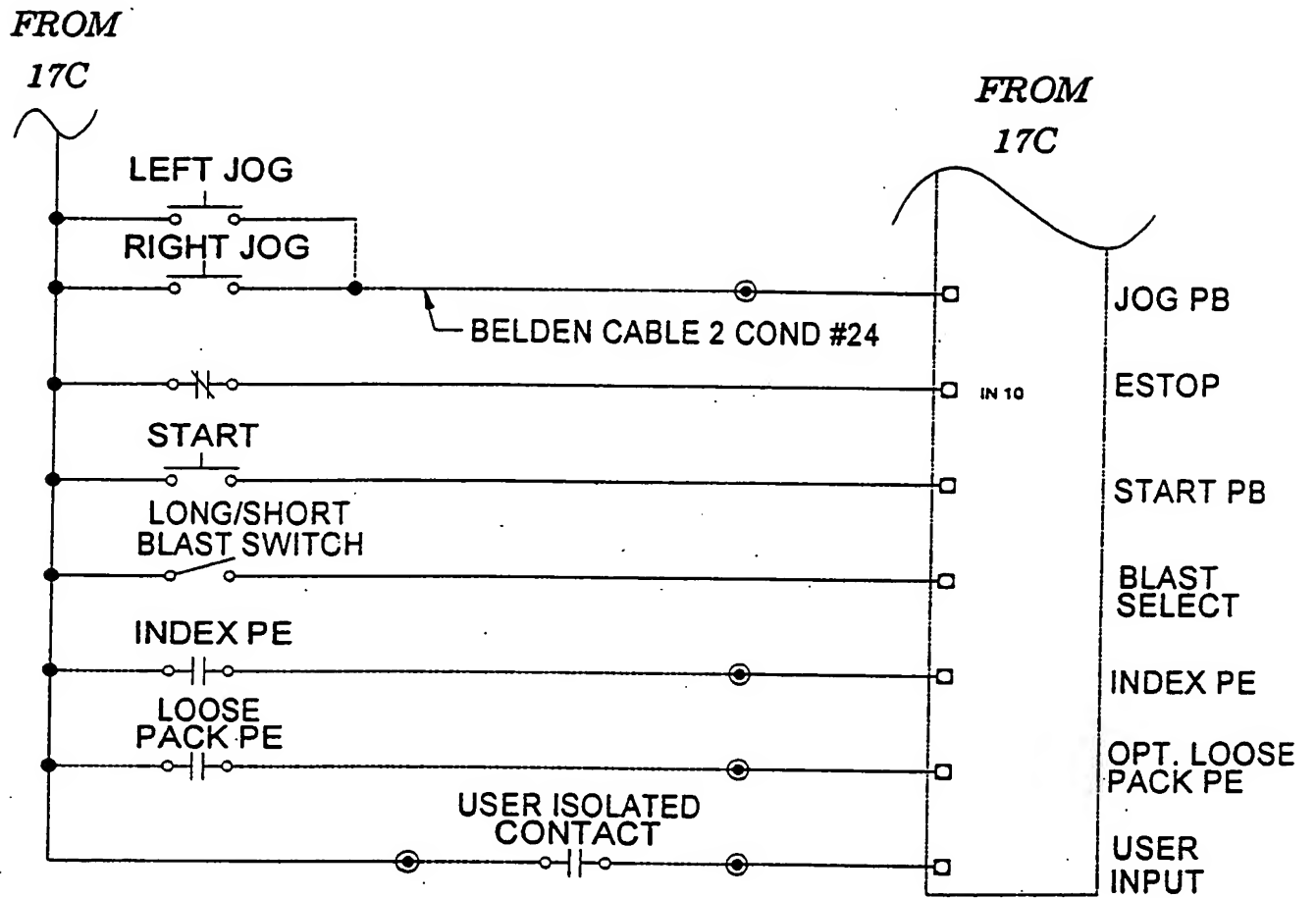




*Fig. 17B*

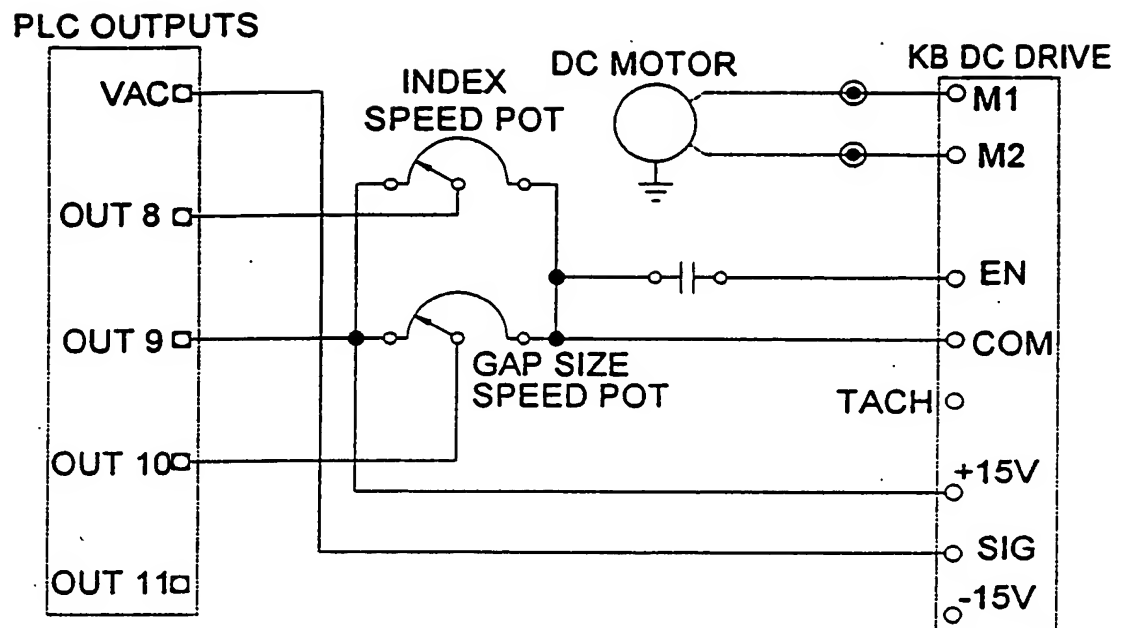


*Fig. 17C*

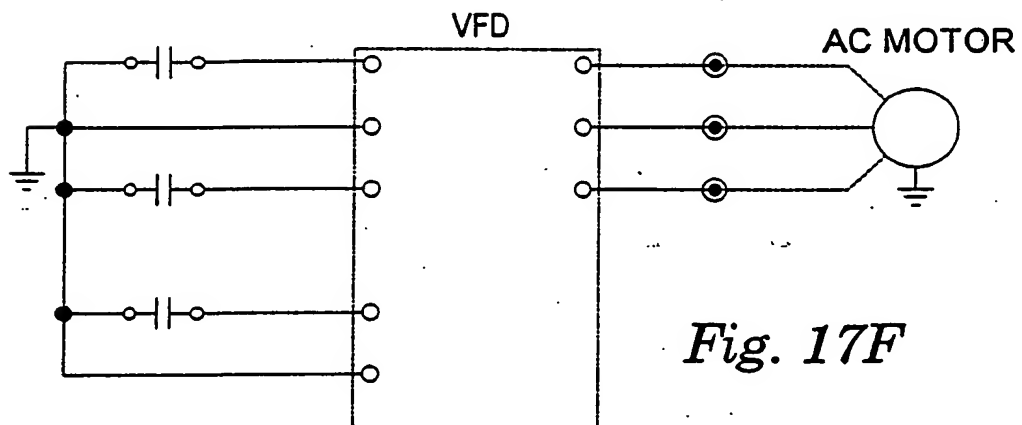


*Fig. 17D*

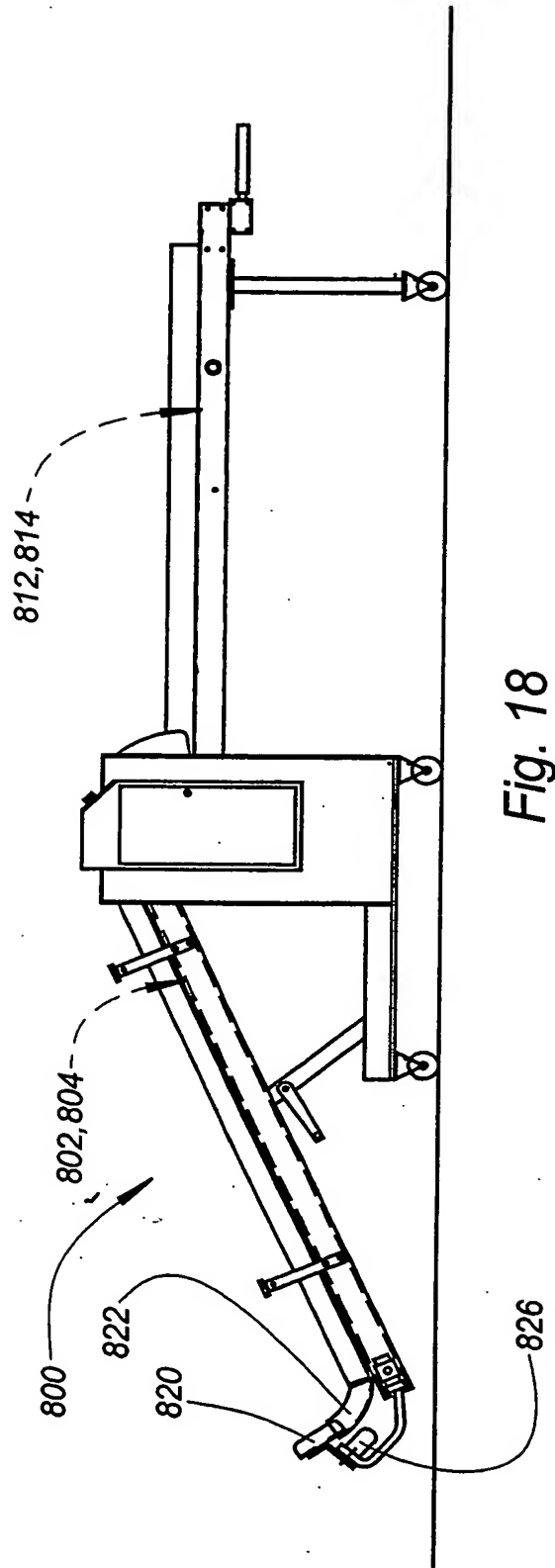
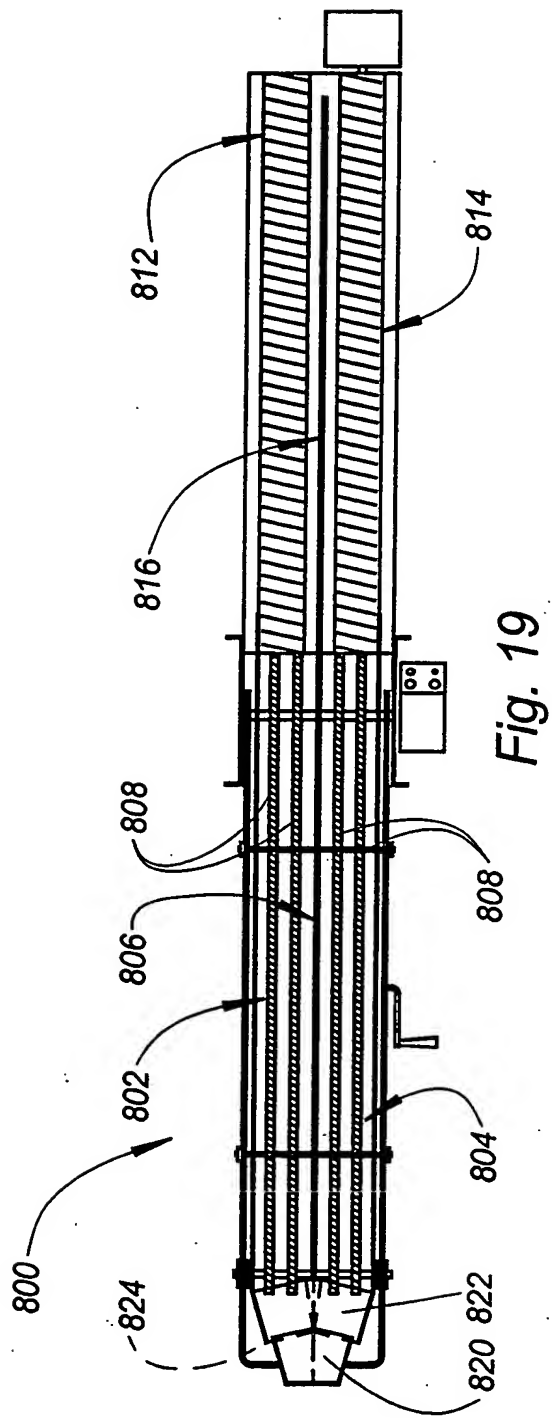


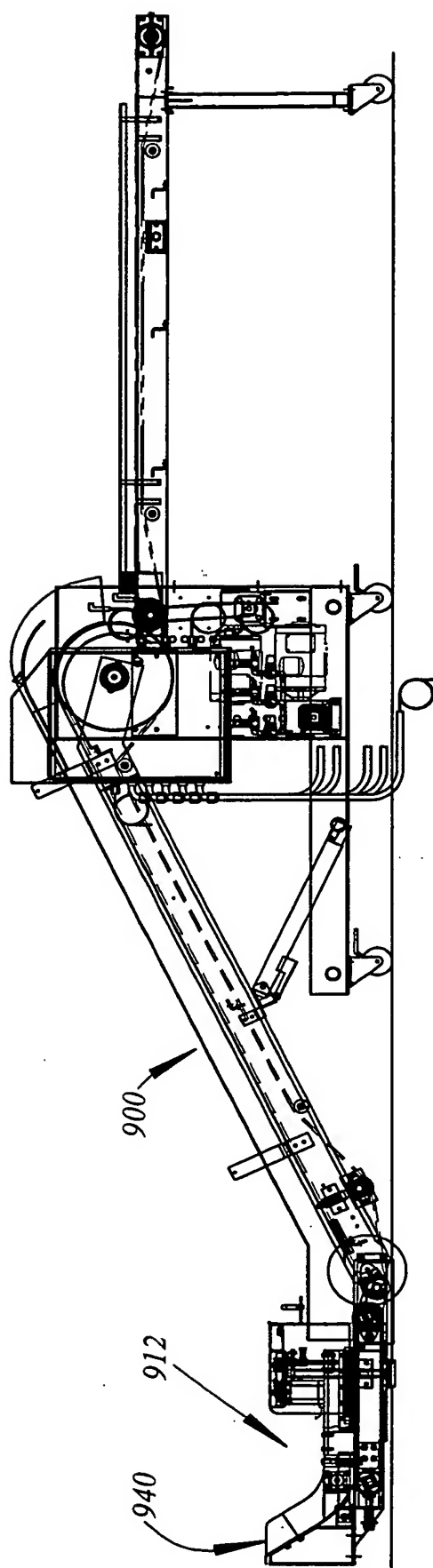
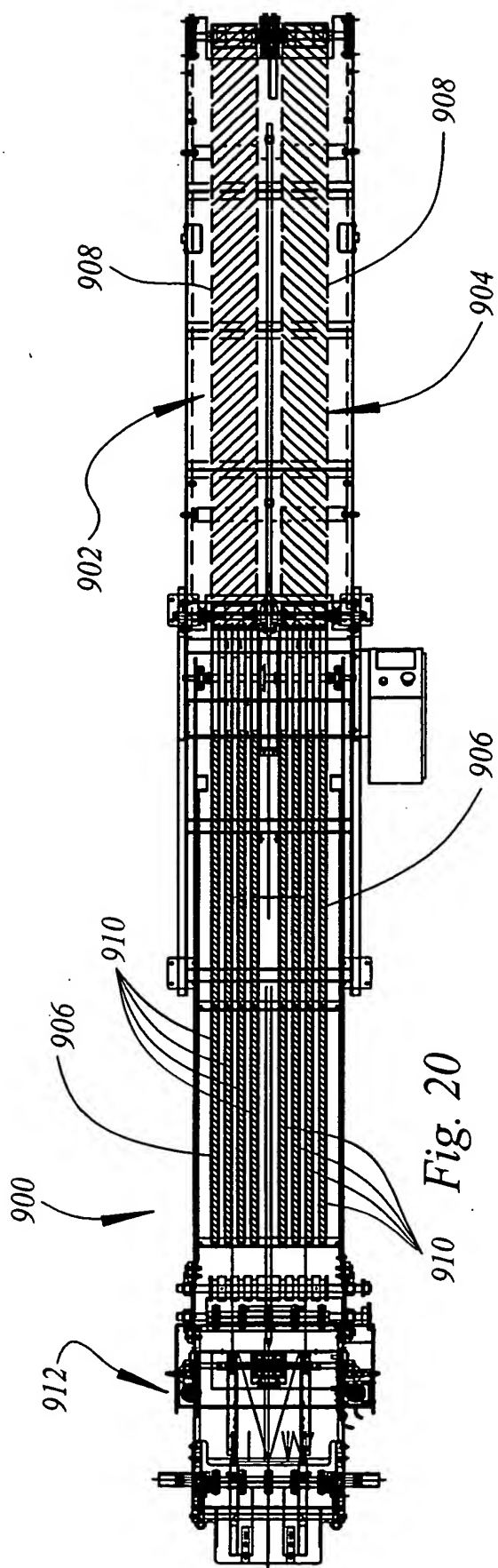


*Fig. 17E*



*Fig. 17F*





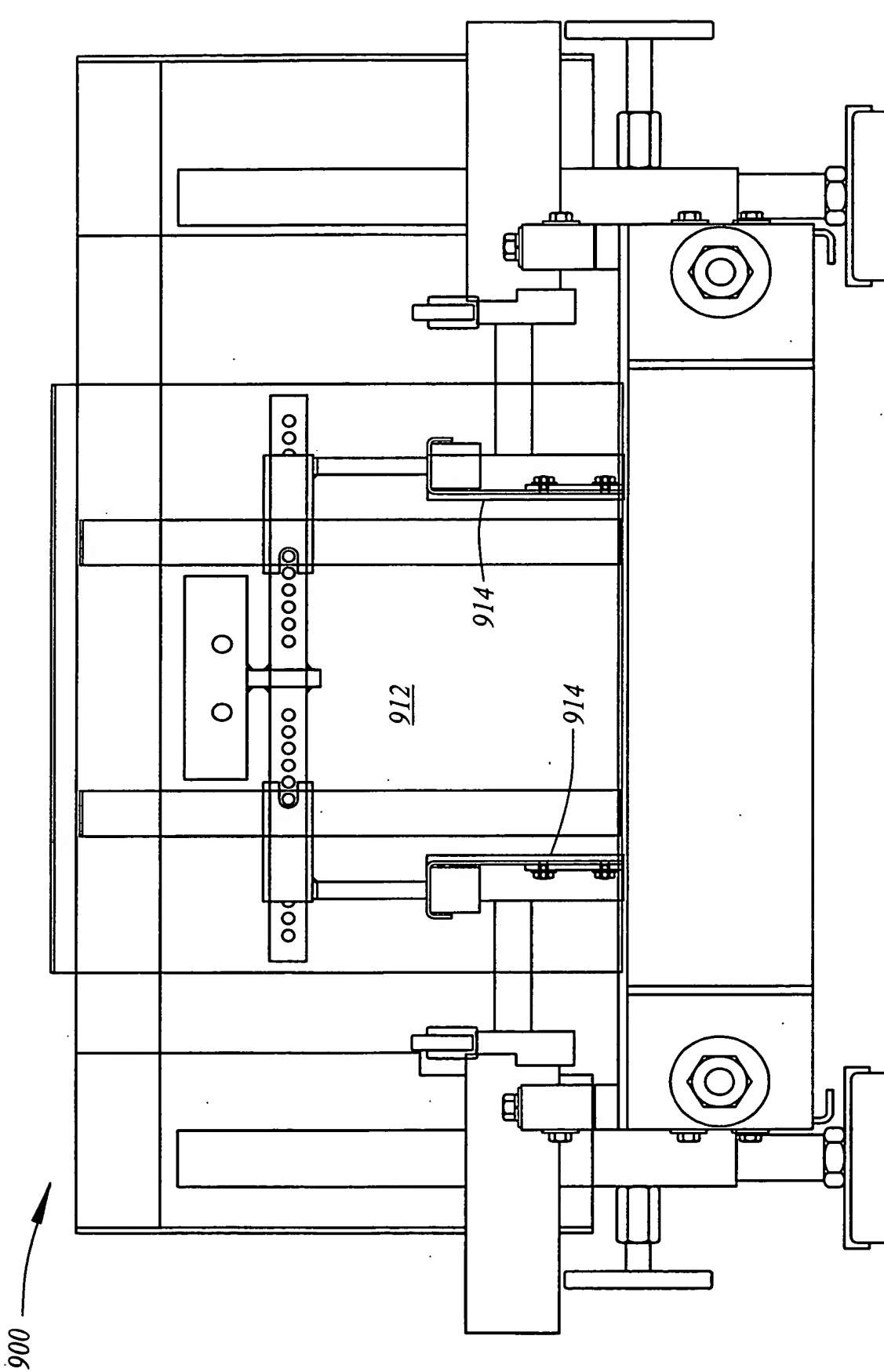


Fig. 22

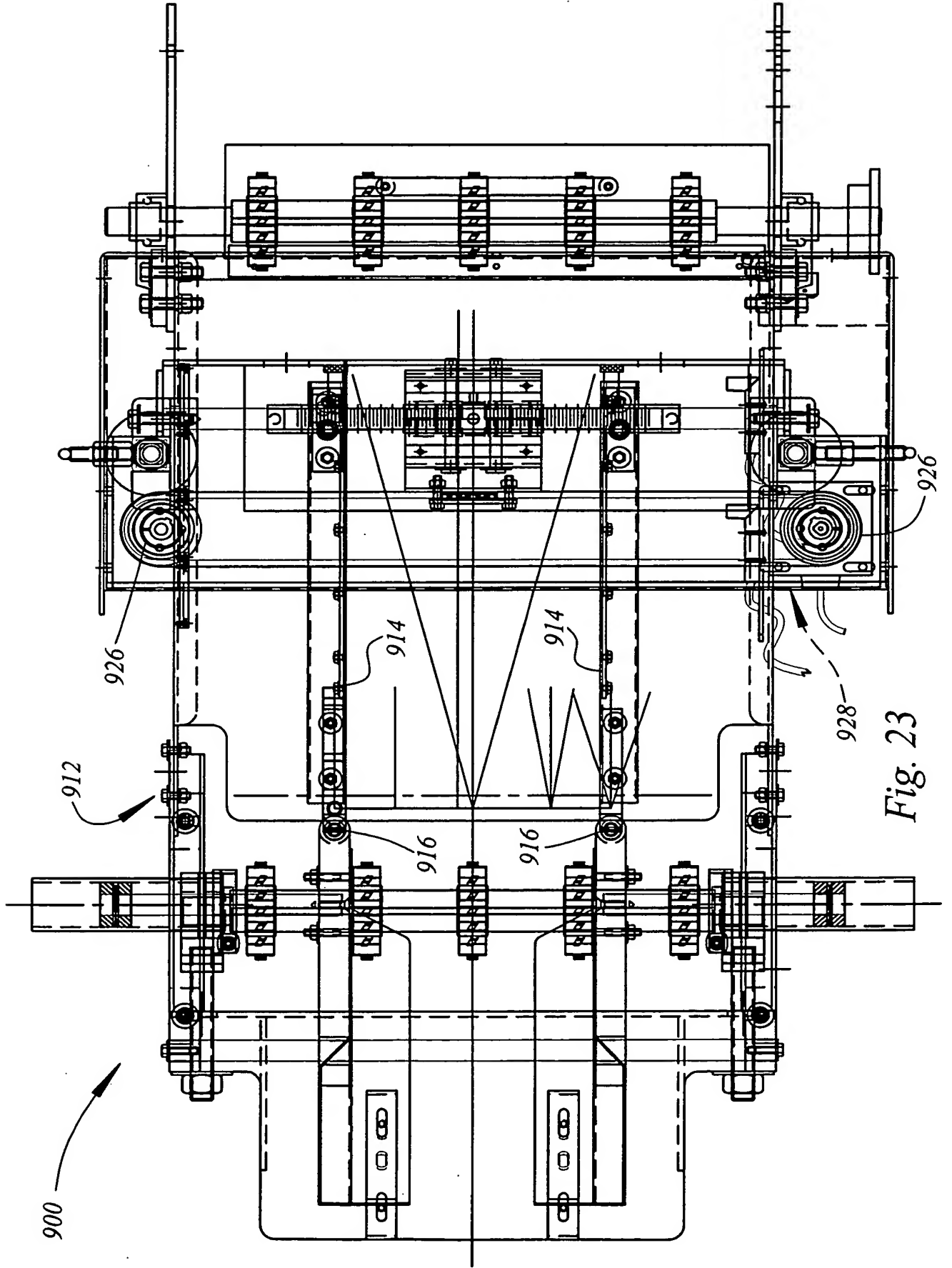


Fig. 23

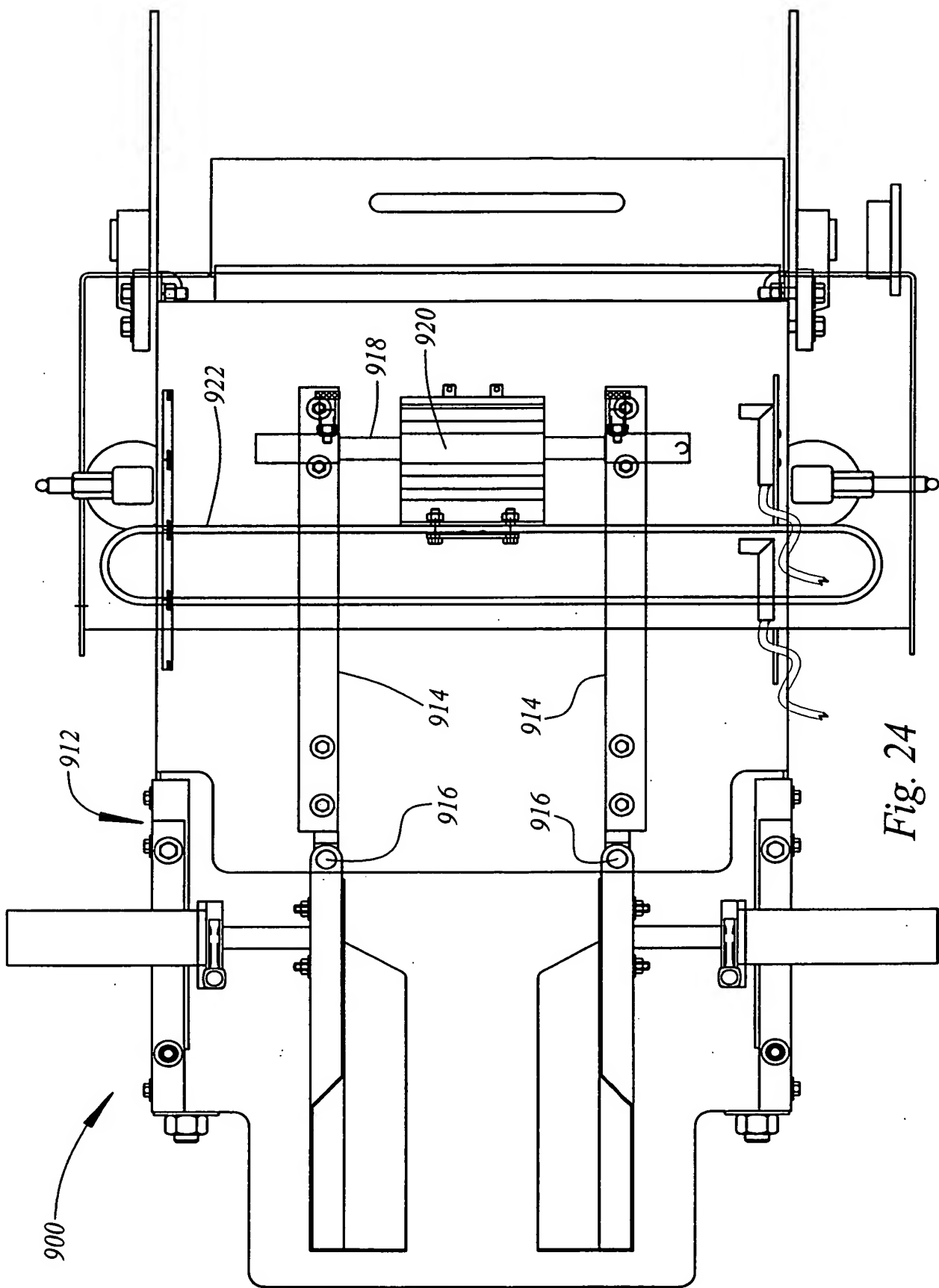


Fig. 24

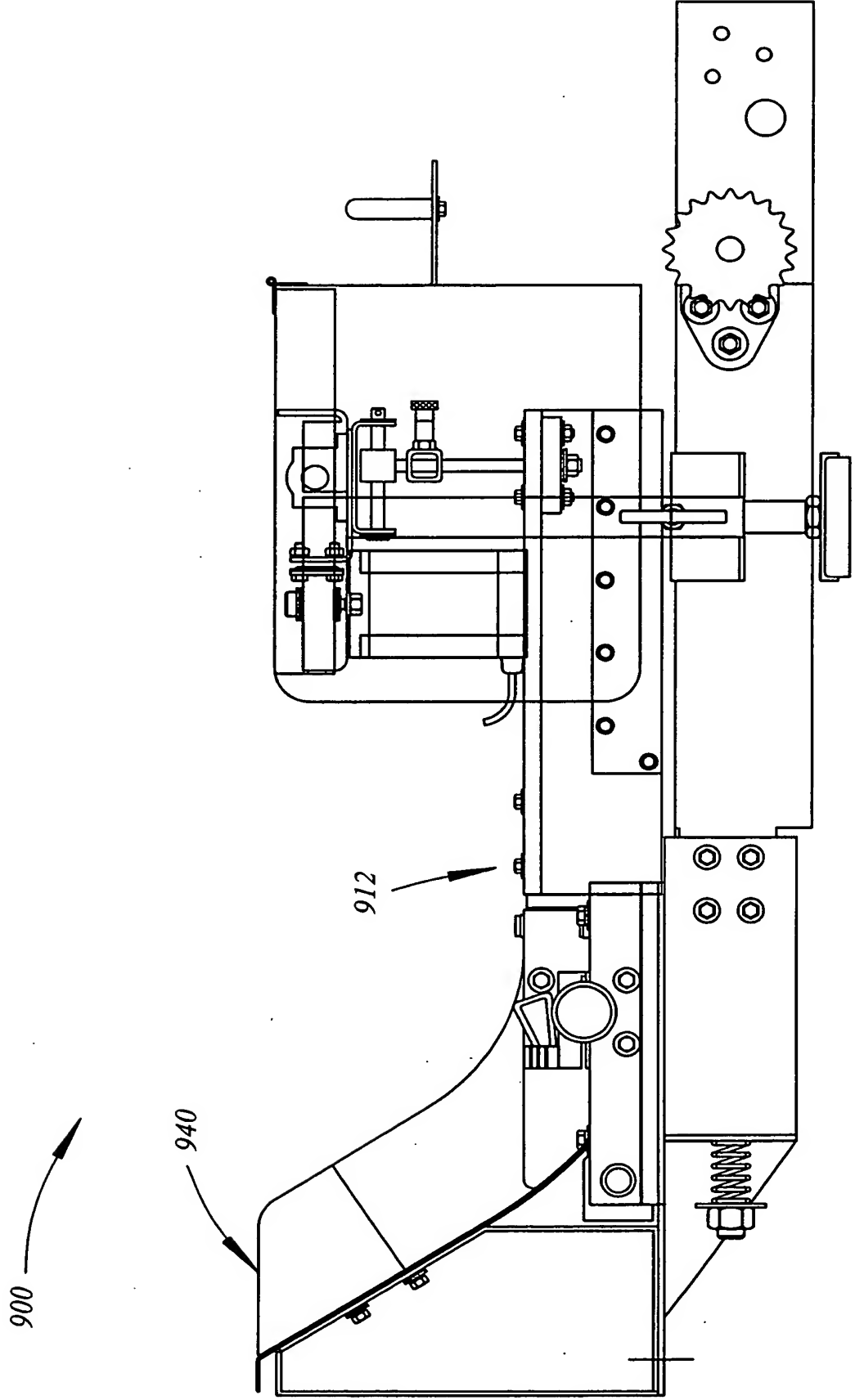


Fig. 25

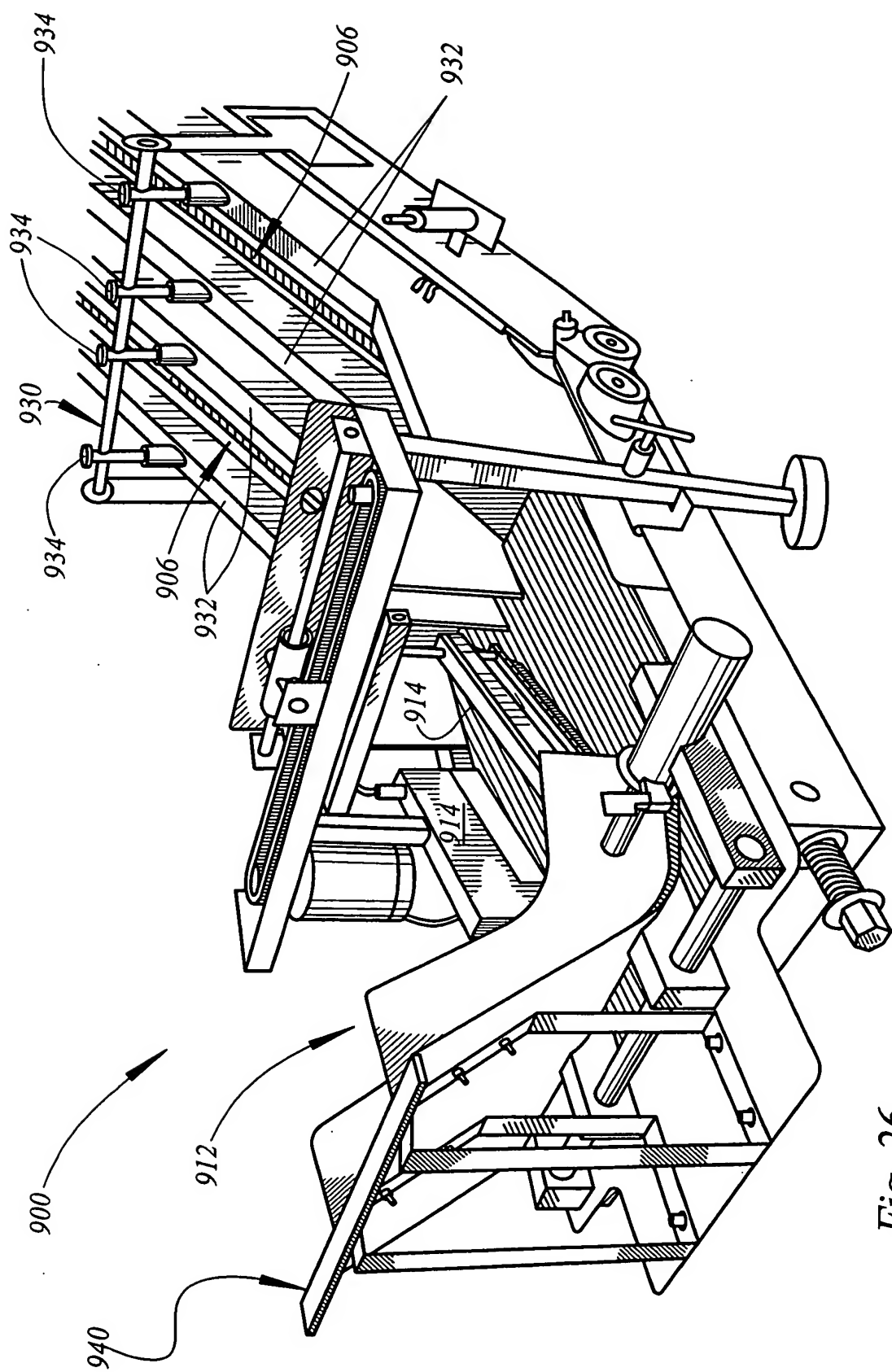


Fig. 26



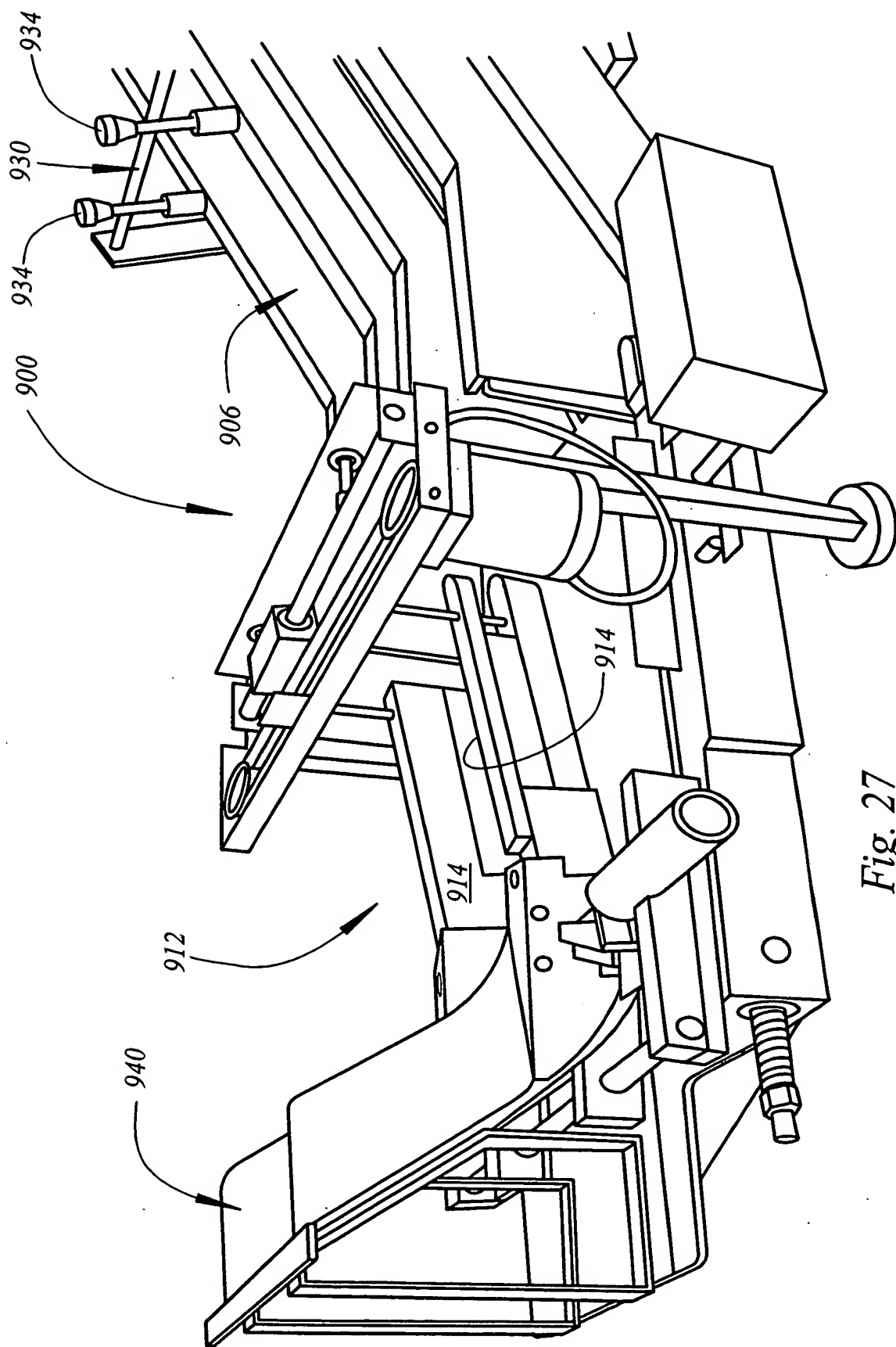


Fig. 27

